

35 TAPE READER (PARALLEL OUTPUT)

ADJUSTMENTS

| CONTENTS  | PAGE | CONTENTS                                       | PAGE |
|---|------|--|------|
| 1. GENERAL . . . . .                                | 2    | Cover plate . . . . .                          | 13   |
| 2. BASIC UNIT . . . . .                             | 5    | Cover plate detent spring . . . . .            | 13   |
| Auxiliary No. 1 Contact Assembly . . . . .          | 30   | Feed wheel post . . . . .                      | 11   |
| Initial Adjustments . . . . .                       | 30   | Latch bail . . . . .                           | 8    |
| Normally open contact spring . . . . .              | 30   | Tape guide . . . . .                           | 9    |
| Normally open contact stiffener . . . . .           | 30   | Tape guide plate . . . . .                     | 11   |
| Swinger . . . . .                                   | 30   | Tape lid . . . . .                             | 12   |
| Secondary Adjustments . . . . .                     | 31   | Tape lid bracket . . . . .                     | 7    |
| Contact assembly . . . . .                          | 31   | Tape lid release button spring . . . . .       | 10   |
| Contact bracket . . . . .                           | 31   | Tape lid spring . . . . .                      | 10   |
| Operating bail spring . . . . .                     | 31   | Top plate . . . . .                            | 12   |
| Final Adjustments (Strobing) . . . . .              | 32   | Main Bail Mechanism . . . . .                  | 20   |
| Contact bracket . . . . .                           | 32   | Feed wheel ratchet detent spring . . . . .     | 20   |
| Clutch Magnet Assembly . . . . .                    | 24   | Locking bail spring . . . . .                  | 23   |
| Armature bail hinge . . . . .                       | 24   | Main bail . . . . .                            | 23   |
| Armature bail spring . . . . .                      | 25   | Main bail spring . . . . .                     | 20   |
| Assembly . . . . .                                  | 25   | Transfer lever guide post . . . . .            | 20   |
| Backstop eccentric . . . . .                        | 24   | Main Shaft and Clutch Trip Mechanism . . . . . | 5    |
| Main bail latch spring . . . . .                    | 25   | Clutch latch lever spring . . . . .            | 5    |
| Code Reading Contacts . . . . .                     | 26   | Clutch shoe lever . . . . .                    | 5    |
| Initial Adjustments . . . . .                       | 26   | Clutch shoe lever spring . . . . .             | 6    |
| Normally closed contacts - backstops . . . . .      | 26   | Clutch shoe spring . . . . .                   | 6    |
| Normally closed contacts - spring tension . . . . . | 26   | Clutch trip lever . . . . .                    | 5    |
| Normally open contacts - backstop . . . . .         | 26   | Clutch trip lever spring . . . . .             | 5    |
| Normally open contacts - spring tension . . . . .   | 26   | Tape Feed Mechanism . . . . .                  | 22   |
| Secondary Adjustments . . . . .                     | 27   | Feed pawl . . . . .                            | 22   |
| Contact assembly . . . . .                          | 27   | Feed pawl spring . . . . .                     | 22   |
| Contact bracket . . . . .                           | 27   | Tape-Out Contact Assembly . . . . .            | 14   |
| Eccentric up-stop . . . . .                         | 28   | Assembly bracket . . . . .                     | 15   |
| Sensing arm spring . . . . .                        | 28   | Break-make contact spring . . . . .            | 14   |
| Split bail eccentric . . . . .                      | 28   | Tape-out pin spring . . . . .                  | 15   |
| Final Adjustments (Strobing) . . . . .              | 29   | Tape-Out Pin Mechanism . . . . .               | 16   |
| Contact bracket . . . . .                           | 29   | Intermediate tape-out bail spring . . . . .    | 17   |
| Cover and Top Plate Area . . . . .                  | 7    | Stop arm . . . . .                             | 16   |
| Bearing bracket . . . . .                           | 7    | Tape-out bail . . . . .                        | 16   |
| Control lever detent spring . . . . .               | 10   | Tape-out torsion spring . . . . .              | 17   |

| CONTENTS                               | PAGE      |
|--|-----------|
| Tape Sensing Mechanism . . . . .       | 21        |
| Feed wheel detent . . . . .            | 21        |
| Sensing finger spring . . . . .        | 21        |
| Transfer lever spring . . . . .        | 22        |
| Tight-Tape Mechanism . . . . .         | 18        |
| Break Contact Spring . . . . .         | 18        |
| Control Contact Assembly Bracket . .   | 18        |
| Control Contact Spring . . . . .       | 19        |
| Intermediate Arm . . . . .             | 19        |
| Intermediate Arm Spring . . . . .      | 19        |
| <b>3. VARIABLE FEATURES . . . . .</b>  | <b>33</b> |
| Auxiliary No. 2 Contacts . . . . .     | 33        |
| Initial Adjustments . . . . .          | 33        |
| Break-make contact spring . . . . .    | 33        |
| Make contact spring . . . . .          | 33        |
| Make contact stiffener . . . . .       | 33        |
| Secondary Adjustments . . . . .        | 34        |
| Cam follower spring . . . . .          | 34        |
| Contact assembly . . . . .             | 34        |
| Contact bracket . . . . .              | 34        |
| Final Adjustments (Strobing) . . . . . | 35        |
| Contact bracket . . . . .              | 35        |

## 1. GENERAL

1.01 This section is concerned with the adjustment of 8-level tape reader units. Refer to related 574-236- series sections for descriptive information, principle of operation, lubrication, disassembly, and reassembly.

1.02 The adjustment information for the tape reader is divided into "basic unit" adjustments (common to all units) and "variable features" adjustments (adjustments which may vary from unit to unit).

1.03 Adjustment requirements for the tape reader are arranged in the sequence that should be followed if a complete readjustment is undertaken.

1.04 Inspection and minor repair of the unit may be accomplished with the plates removed, however, when more extensive maintenance or a complete readjustment is undertaken, the tape reader should be disconnected from any AC or DC potential and removed from its base.

Note: For instructions on the disassembly and reassembly of the tape reader, see related disassembly and reassembly section.

1.05 References made to left or right, up or down, front or rear, etc consider the tape reader to be viewed from a position such that the tape guide plate is to the viewer's right and on top of the tape reader.

1.06 Tools and spring scales required to perform the adjustments are listed in the appropriate section. They are not supplied as a part of the equipment.

1.07 From time to time the requirements and procedures for the various adjustments may change. For this reason, the text of the adjustment in the latest issue should be read through before proceeding to make the adjustment.

1.08 The adjusting illustrations, in addition to indicating the adjusting tolerances, positions of parts, and spring tensions, also show the way in which the scale should be positioned when measuring spring tensions.

1.09 The spring tensions given in this section are indications, not exact values. They should be checked with proper spring scales in the positions indicated. Springs which do not meet the requirement and for which no adjusting procedure is given should be replaced by a new spring.

1.10 After an adjustment has been completed, be sure to tighten any nuts or screws that may have been loosened.

1.11 If a part that is mounted with shims is removed, the number of shims at each of its mounting screws should be noted so that the same shim pile-up will be replaced when the part is remounted.

1.12 If parts or assemblies are removed to facilitate readjustment and subsequently replaced, recheck any adjustment that may have been affected by the removal of these parts or assemblies.

1.13 When the requirement calls for the clutch to be disengaged, the clutch shoe lever must be fully latched between its trip lever and the latch lever so that the clutch shoes release their tension on the clutch drum. When engaged, the clutch shoe lever is unlatched and the clutch shoes are wedged firmly against the clutch drum.

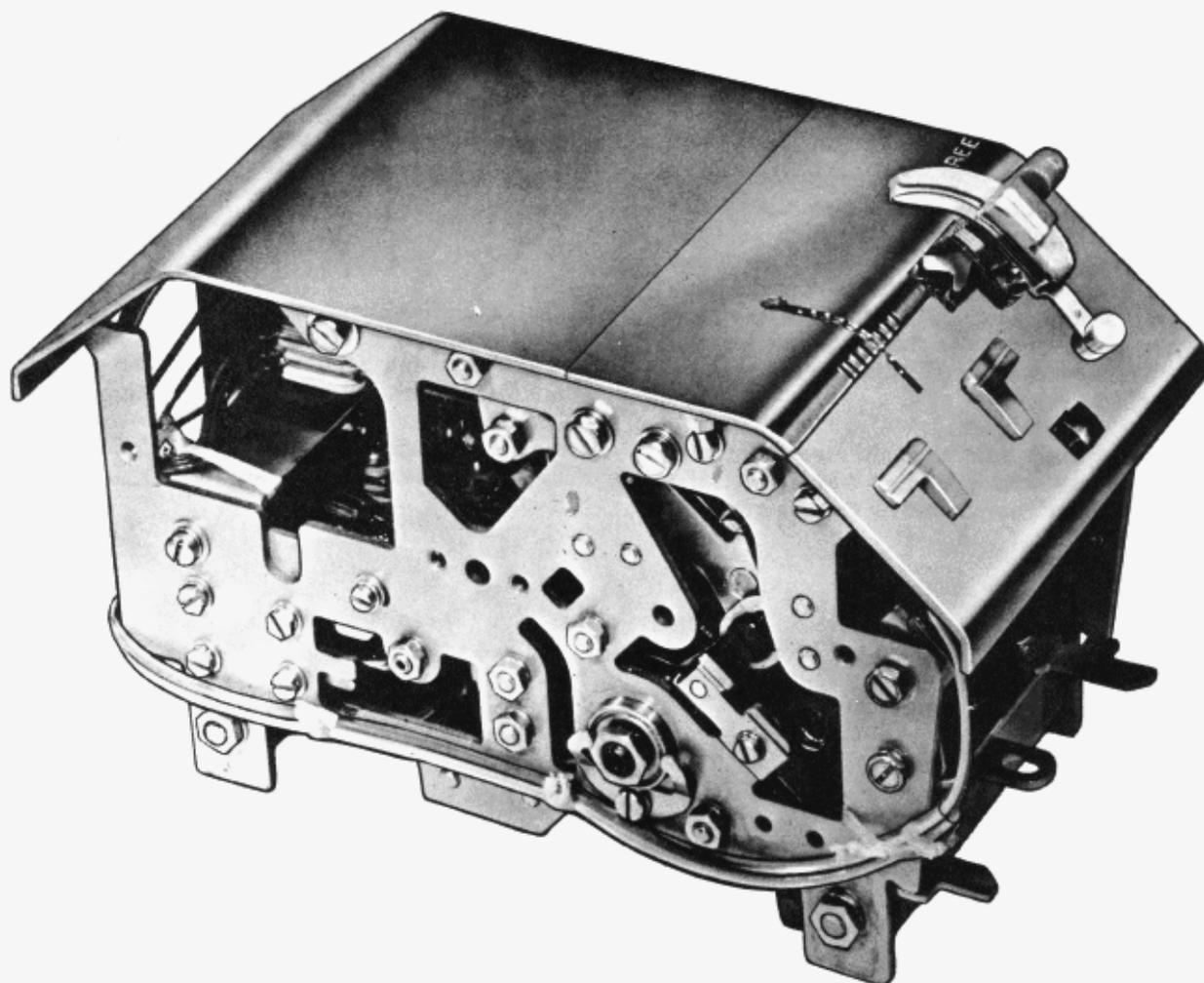


Figure 1 - Tape Reader

Note 1: When rotating the main shaft by hand, the clutch does not fully disengage upon reaching its stop position. In order to relieve the drag on the clutch and permit the main shaft to rotate freely, apply pressure on a lug of the clutch disc with a screw driver to cause it to engage its latch lever and thus disengage the internal expansion clutch shoes from the clutch drum.

Note 2: The stop position refers to that position where the shoe lever contacts the trip lever with the main bail latched.

1.14 When adjusting contact gaps and spring tensions of contact assemblies with more than one contact pile-up such as code reading contact assemblies, start adjusting with the contact pile-up farthest from the handle of the bending tool. Work towards the contact pile-up nearest the bending tool handle. In this manner completed adjustments will not be disturbed.

1.15 All contact points should meet squarely. Contacts with the same diameter should not be out of alignment more than 25 per cent

of the contact diameter. Avoid sharp kinks or bends in the contact springs.

1.16 Should the rotor of the synchronous motor become blocked for several seconds by an overload, the thermal cut-out switch will de-energize the motor until the manual reset button is depressed. However, allow at least 5 minutes for the motor to cool before attempting to reset the switch and start the motor.

**CAUTION: IMPROPERLY ADJUSTED EQUIPMENT MAY BE SERIOUSLY DAMAGED IN A MATTER OF SECONDS IF OPERATED UNDER POWER. CHECK ALL ADJUSTMENTS BEFORE PUTTING THE TAPE READER INTO OPERATION.**

1.17 The line drawings show adjusting tolerances, position of parts, and spring tensions for the tape reader. Where several adjustments are shown on the same page, the sequence to be followed in checking the requirements and making the adjustments is indicated by the letters (A), (B), (C), etc.

2. BASIC UNIT

2.01 Main Shaft and Clutch Trip Mechanisms

(A) CLUTCH TRIP LEVER  
TO CHECK  
STOP LUG OPPOSITE TRIP LEVER.

(1) REQUIREMENT  
MIN 0.012 INCH ---  
MAX 0.025 INCH  
BETWEEN STOP LUG  
AND TRIP LEVER WITH  
PLAY TAKEN UP TO  
MAKE A MAXIMUM  
CLEARANCE.

(2) REQUIREMENT  
SOME CLEARANCE BE-  
TWEEN STOP LUG AND  
TRIP LEVER WITH PLAY  
TAKEN UP TO MAKE A  
MINIMUM CLEAR-  
ANCE.

TO ADJUST  
LOOSEN NUT ON ECCEN-  
TRIC POST FRICTION TIGHT.  
ROTATE ECCENTRIC POST  
TO ITS LOWERMOST POSI-  
TION OR UNTIL REQUIRE-  
MENT IS MET.

(D) CLUTCH SHOE LEVER  
TO CHECK  
CLUTCH DISENGAGED. MEASURE GAP BETWEEN STOP LUG  
AND SHOE LEVER.

REQUIREMENT  
WITH CLUTCH ENGAGED,  
MIN 0.055 INCH --- MAX 0.085 INCH  
GREATER GAP BETWEEN STOP LUG AND SHOE LEVER THAN  
WHEN DISENGAGED.

TO ADJUST  
LOOSEN CLAMP SCREWS. ROTATE ADJUSTING PLATE BY  
ENGAGING ADJUSTING PLATE EXTENSION WITH WRENCH OR SCREWDRIVER.

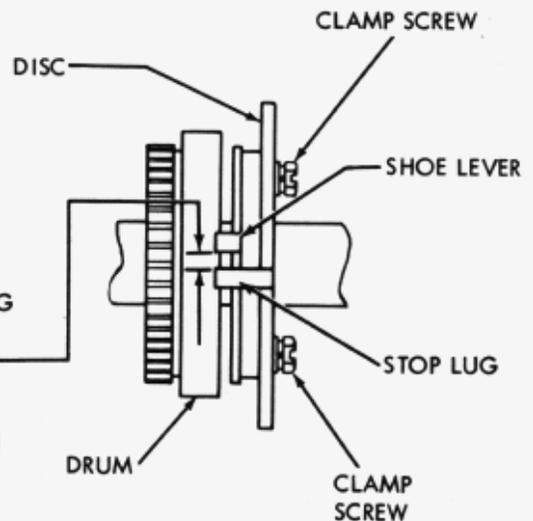
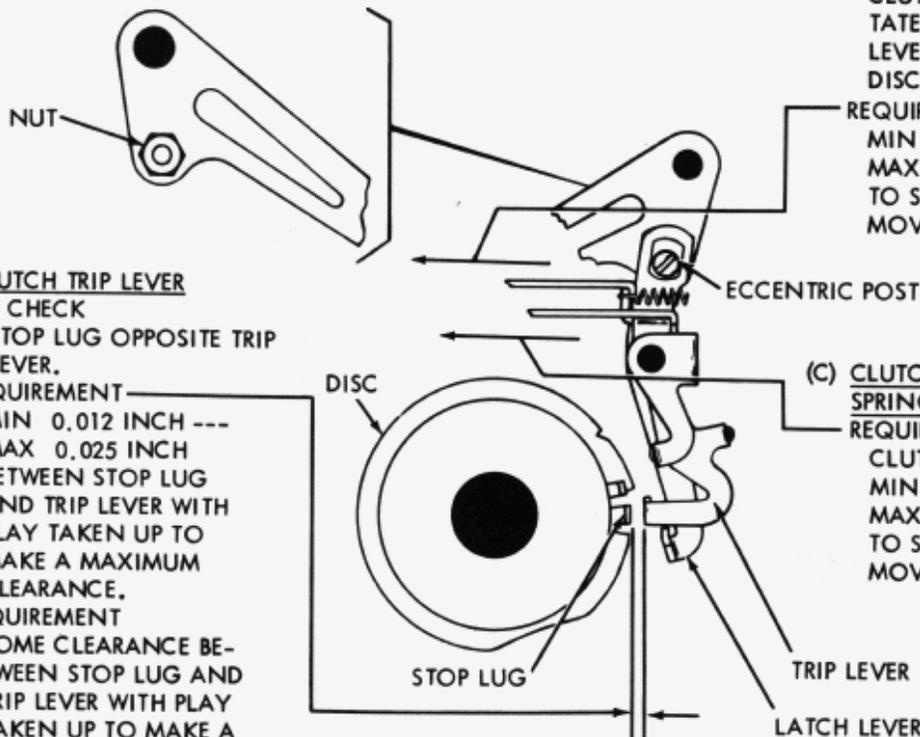
NOTE

1. POSITIVELY ENGAGE CLUTCH BY PULLING SHOE LEVER WITH A FORCE OF 32 OZ. RELEASE SLOWLY.
2. ADJUST TOWARDS MINIMUM REQUIREMENT ON TWO-STOP CLUTCHES.
3. AFTER MAKING ABOVE ADJUSTMENT, DISENGAGE CLUTCH. ROTATE DRUM IN NORMAL DIRECTION AND CHECK TO SEE IF IT DRAGS ON SHOE. IF IT DOES, REFINE ADJUSTMENT.

(B) CLUTCH LATCH LEVER  
SPRING  
TO CHECK  
CLUTCH ENGAGED. RO-  
TATE CLUTCH UNTIL LATCH  
LEVER IS ON LOW PART OF  
DISC.

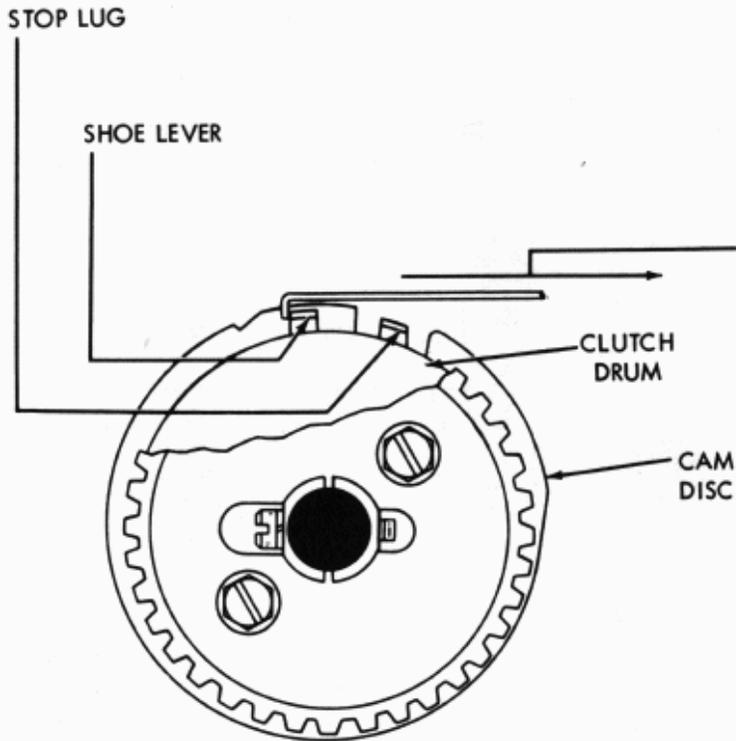
REQUIREMENT  
MIN 3 OZ  
MAX 5-1/2 OZ  
TO START LATCH LEVER  
MOVING.

(C) CLUTCH TRIP LEVER  
SPRING  
REQUIREMENT  
CLUTCH ENGAGED.  
MIN 7 OZ ---  
MAX 10-1/2 OZ  
TO START TRIP LEVER  
MOVING.

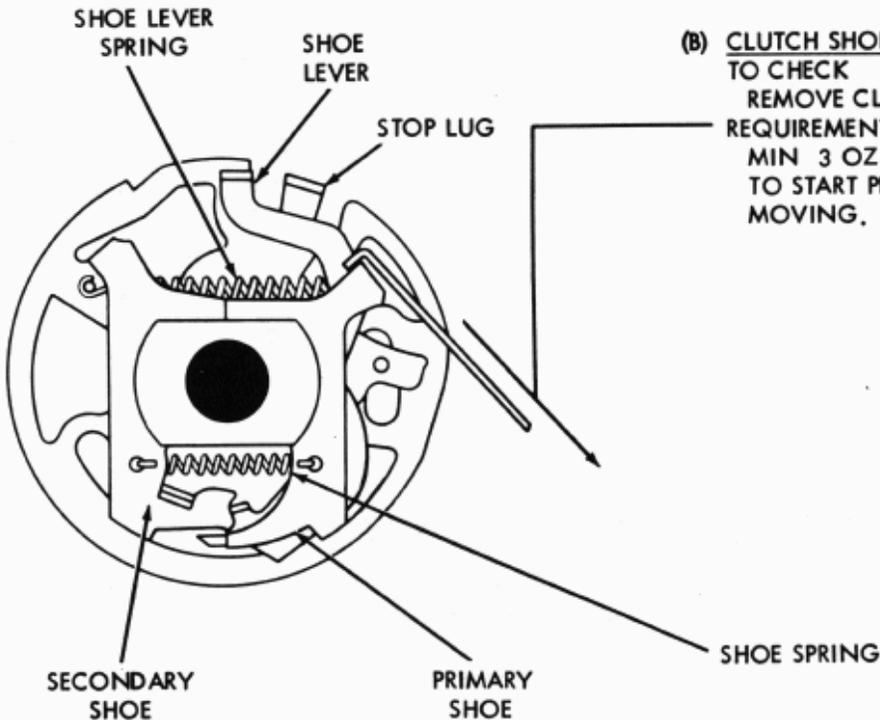


2.02 Main Shaft and Clutch Trip Mechanism (continued)

NOTE  
CLUTCH SHOE LEVER SPRING AND CLUTCH SHOE SPRING ADJUSTMENTS ARE PERFORMED AT FACTORY. THEY SHOULD NOT BE DISTURBED UNLESS ASSOCIATED MECHANISMS HAVE BEEN REMOVED FOR SERVICING OR THERE IS REASON TO BELIEVE THAT THE REQUIREMENTS ARE NOT MET.

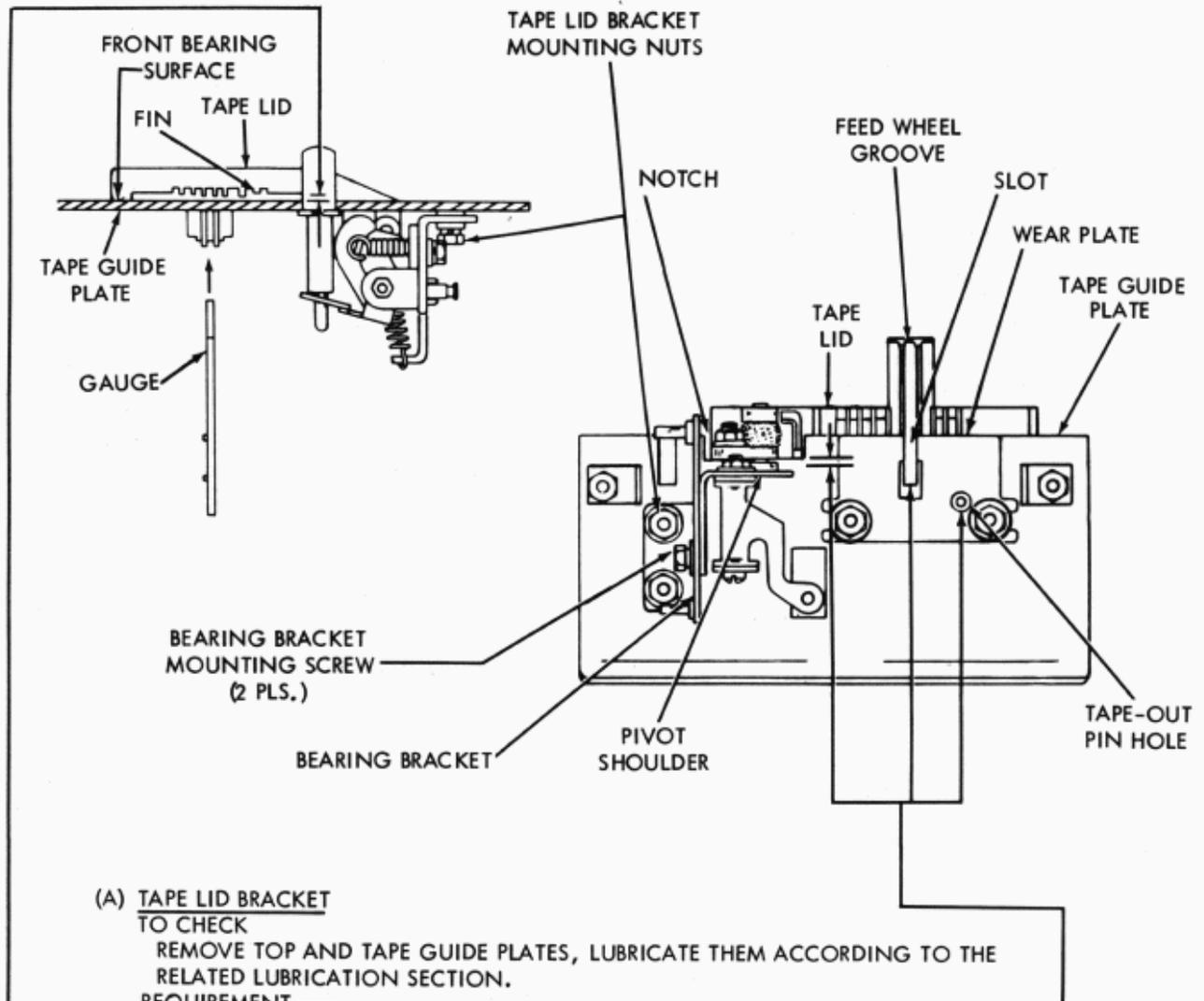


(A) CLUTCH SHOE LEVER SPRING REQUIREMENT  
CLUTCH ENGAGED,  
MIN 15 OZ ---  
MAX 20 OZ  
TO MOVE SHOE LEVER INTO CONTACT WITH STOP LUG.



(B) CLUTCH SHOE SPRING  
TO CHECK  
REMOVE CLUTCH DRUM.  
REQUIREMENT  
MIN 3 OZ --- MAX 5 OZ  
TO START PRIMARY SHOE MOVING.

## 2.03 Cover and Top Plate Area

**(A) TAPE LID BRACKET****TO CHECK**

REMOVE TOP AND TAPE GUIDE PLATES, LUBRICATE THEM ACCORDING TO THE RELATED LUBRICATION SECTION.

**REQUIREMENT**

WITH TAPE LID PRESSED AGAINST NOTCH IN TAPE GUIDE PLATE, FEED WHEEL GROOVE LINED UP WITH SLOT IN TAPE GUIDE PLATE, AND TAPE-OUT PIN HOLES LINED UP,  
MIN SOME --- MAX 0.010 INCH  
CLEARANCE BETWEEN TAPE LID AND PIVOT SHOULDER.

**TO ADJUST**

LOOSEN TAPE LID BRACKET MOUNTING NUTS. WHILE PRESSING TAPE LID AGAINST NOTCH IN TAPE GUIDE PLATE, LINE UP FEED WHEEL GROOVE WITH SLOT IN TAPE GUIDE PLATE USING TIP OF TP170283 GAUGE. VISUALLY LINE UP TAPE-OUT PIN HOLE IN TAPE GUIDE PLATE WITH HOLE IN TAPE LID. POSITION TAPE LID BRACKET.

**(B) BEARING BRACKET****REQUIREMENT**

WITH FRONT BEARING SURFACE OF TAPE LID TOUCHING TAPE GUIDE PLATE,  
MIN 0.010 INCH --- MAX 0.018 INCH  
CLEARANCE BETWEEN TAPE LID AND TAPE GUIDE PLATE MEASURED AT TAPE LID FIN THAT IS IN LINE WITH REAR TAPE GUIDE.

**TO ADJUST**

LOOSEN BEARING BRACKET MOUNTING SCREWS FRICTION TIGHT. WHILE PRESSING TAPE LID AGAINST TAPE GUIDE PLATE, POSITION BEARING BRACKET. RECHECK 2.03(A).

2.04 Cover and Top Plate Area (continued)

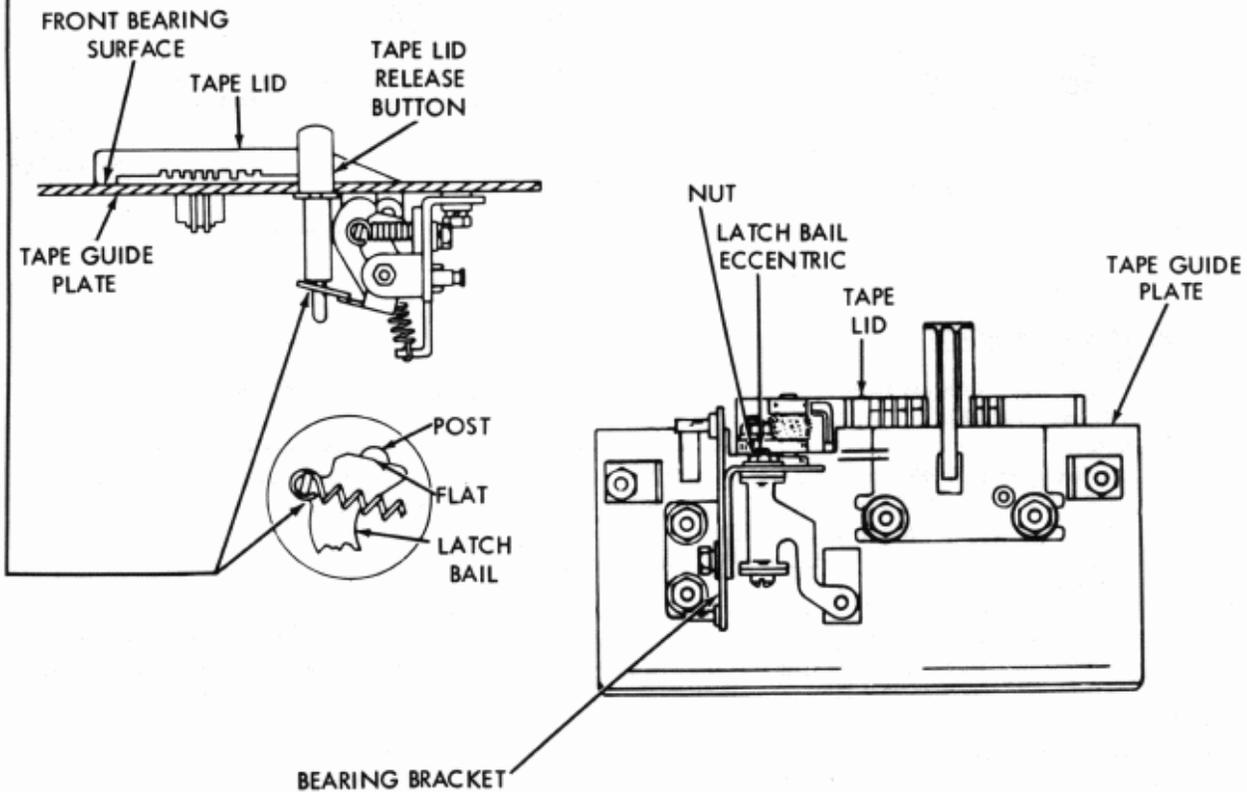
NOTE

WHEN BOTH TOP AND TAPE GUIDE PLATES ARE ASSEMBLED ON UNIT, THE FRONT BEARING SURFACE OF THE TAPE LID MAY TOUCH TOP PLATE. IF IT DOES, THERE MAY BE CLEARANCE BETWEEN TAPE LID AND TAPE GUIDE PLATE.

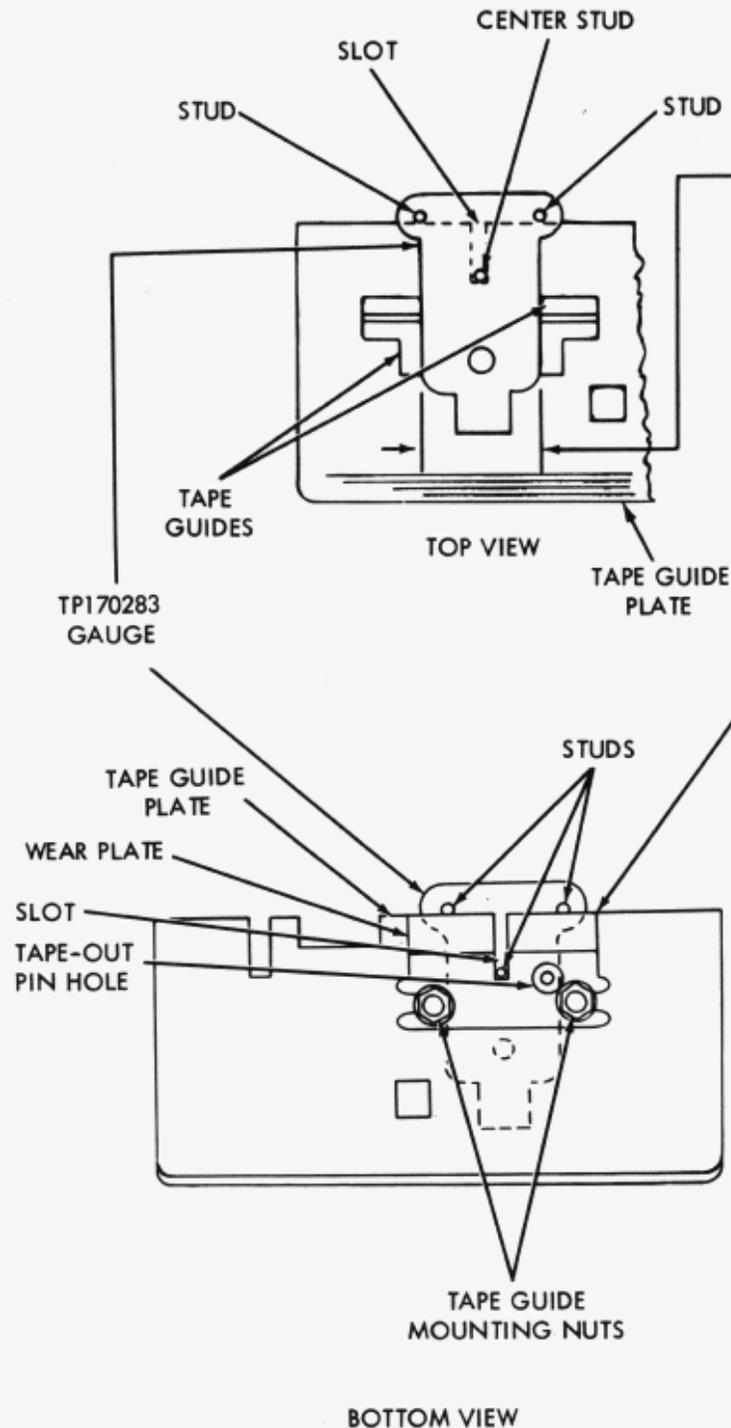
**LATCH BAIL REQUIREMENT**

WITH TAPE LID LATCHED AGAINST TAPE GUIDE PLATE, SOME END PLAY IN TAPE LID RELEASE BUTTON. TO ADJUST

LOOSEN NUT ON LATCH BAIL ECCENTRIC FRICITION TIGHT. RAISE TAPE LID AND ROTATE HIGH PART OF LATCH BAIL ECCENTRIC TOWARDS BEARING BRACKET. CLOSE TAPE LID AND CONTINUE ROTATING HIGH PART OF LATCH BAIL ECCENTRIC TOWARDS BEARING BRACKET UNTIL LATCH BAIL JUST FALLS UNDER THE FLAT ON THE POST. RECHECK OPERATION OF LATCH BAIL BY DEPRESSING TAPE LID RELEASE BUTTON WITH TAPE LID HELD DOWN.



2.05 Cover and Top Plate Area (continued)

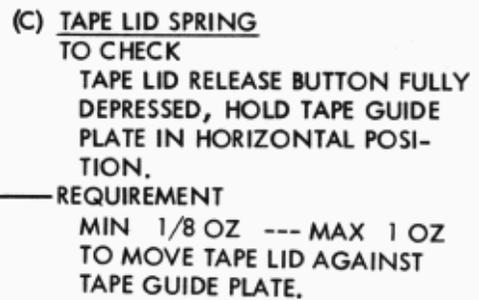
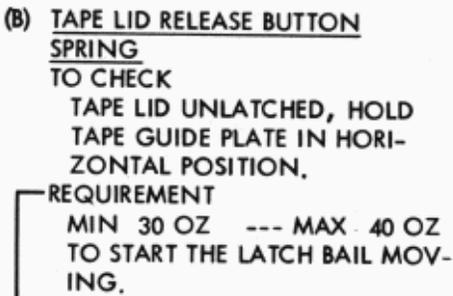
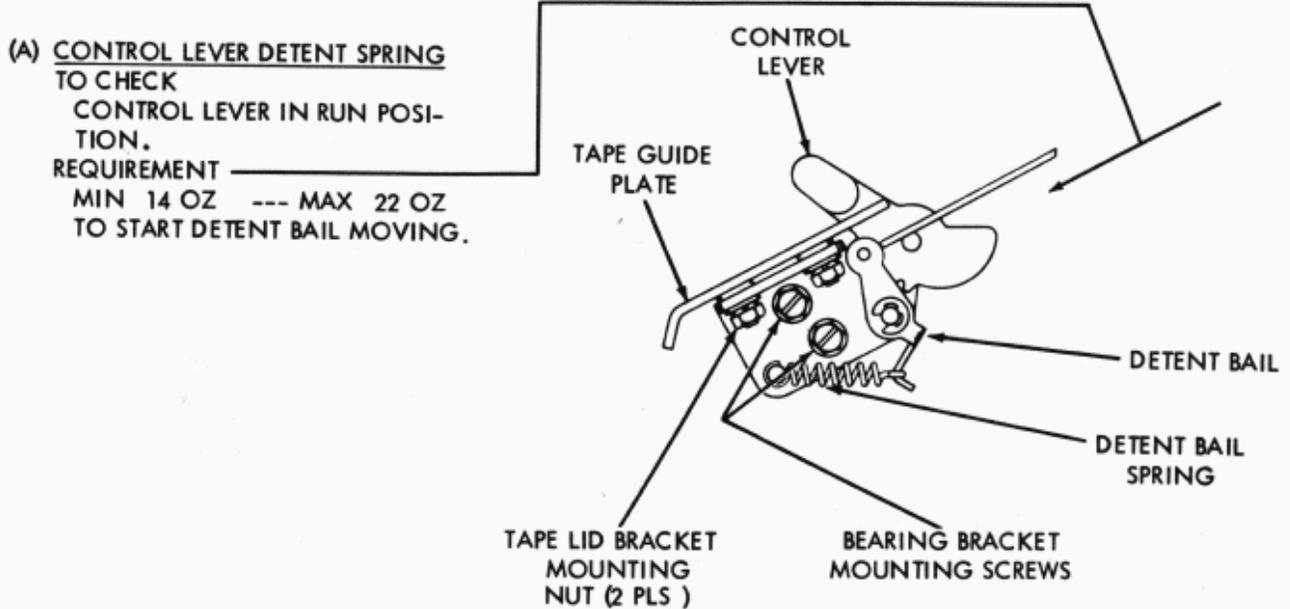


- TAPE GUIDE REQUIREMENT**
- (1) REQUIREMENT  
MIN SOME --- MAX 0.003 INCH  
CLEARANCE BETWEEN GAUGE  
AND TAPE GUIDES.
  - (2) REQUIREMENT  
EDGE OF WEAR PLATE FLUSH  
WITH EDGE OF TAPE GUIDE  
PLATE.
  - (3) REQUIREMENT  
NO RIDING OF TAPE UP THE  
SIDES OF TAPE GUIDES.
- TO ADJUST**  
 LOOSEN TAPE GUIDE MOUNTING  
 NUTS FRICTION TIGHT.  
 POSITION WEAR PLATE UNTIL  
 IT OVERHANGS TAPE GUIDE  
 PLATE. UNLATCH TAPE LID  
 AND PLACE TP170283 GAUGE  
 BETWEEN TAPE GUIDES WITH  
 CENTER STUD OF GAUGE  
 IN FEED HOLE SLOT OF TAPE  
 GUIDE PLATE AND WEAR PLATE.  
 PUSH GAUGE HORIZONTALLY  
 UNTIL REMAINING TWO STUDS  
 OF GAUGE BUTT UP AGAINST  
 TAPE GUIDE PLATE THUSLY PO-  
 SITIONING EDGE OF WEAR  
 PLATE FLUSH WITH EDGE OF  
 TAPE GUIDE PLATE. TIGHTEN  
 ONE TAPE GUIDE MOUNTING  
 NUT. POSITION SECOND TAPE  
 GUIDE TO MEET REQUIREMENT  
 (1). TIGHTEN SECOND TAPE  
 GUIDE MOUNTING NUT.  
 LOOSEN FIRST TAPE GUIDE  
 MOUNTING NUT FRICTION  
 TIGHT AND POSITION TAPE  
 GUIDE TO MEET REQUIREMENT  
 (1). TIGHTEN FIRST TAPE  
 GUIDE MOUNTING NUT.

**NOTE**  
 TAPE GUIDES MAY TOUCH  
 GAUGE, BUT MUST NOT BIND  
 AGAINST GAUGE WHEN IT IS  
 REMOVED.

SECTION 574-236-700

2.06 Cover and Top Plate Area (continued)



## 2.07 Cover and Top Plate Area (continued)

## NOTE

TO PREVENT DAMAGE TO THE TAPE-OUT PIN (2.10), POSITION STOP ARM (2.12) TO ITS LOWERMOST POSITION AND HOLD CONTROL LEVER BAIL EXTENSION (2.14) FROM FEED WHEEL RATCHET (2.18).

(A) FEED WHEEL POST  
REQUIREMENT

FEED WHEEL POST IS NOT TO INTERFERE WITH TOP OR TAPE GUIDE PLATE MOUNTING BRACKETS. TO ADJUST

LOOSEN MOUNTING NUT AND ROTATE POST TO MEET REQUIREMENT.

(B) TAPE GUIDE PLATE(1) REQUIREMENT

TAPE GUIDE PLATE TO REST FIRMLY AGAINST A MINIMUM OF THREE OF THE FOUR PROJECTIONS ON FRONT AND REAR PLATES.

TO ADJUST

ROTATE MAINSHAFT TO ITS STOP POSITION AND TRIP CLUTCH TO PUT SENSING FINGERS (2.20) IN THEIR UPPERMOST POSITION. UNLATCH TAPE LID AND PLACE CONTROL LEVER IN RUN POSITION. LOOSEN MOUNTING SCREWS AND MOUNTING BRACKET NUTS FRICTION TIGHT. POSITION TAPE GUIDE PLATE ON UNIT MAKING CERTAIN THAT TAPE GUIDE PLATE IS FIRMLY POSITIONED TO MEET REQUIREMENT. POSITION TAPE-OUT PIN (2.10) INTO HOLE IN TAPE GUIDE PLATE. TIGHTEN MOUNTING SCREWS.

## NOTE

MOUNTING BRACKET NUTS LOOSENED IN REQUIREMENT (1) ABOVE ARE TIGHTENED AFTER PERFORMING ADJUSTMENT 2.08 AND REQUIREMENT (2) BELOW.

(2) REQUIREMENT

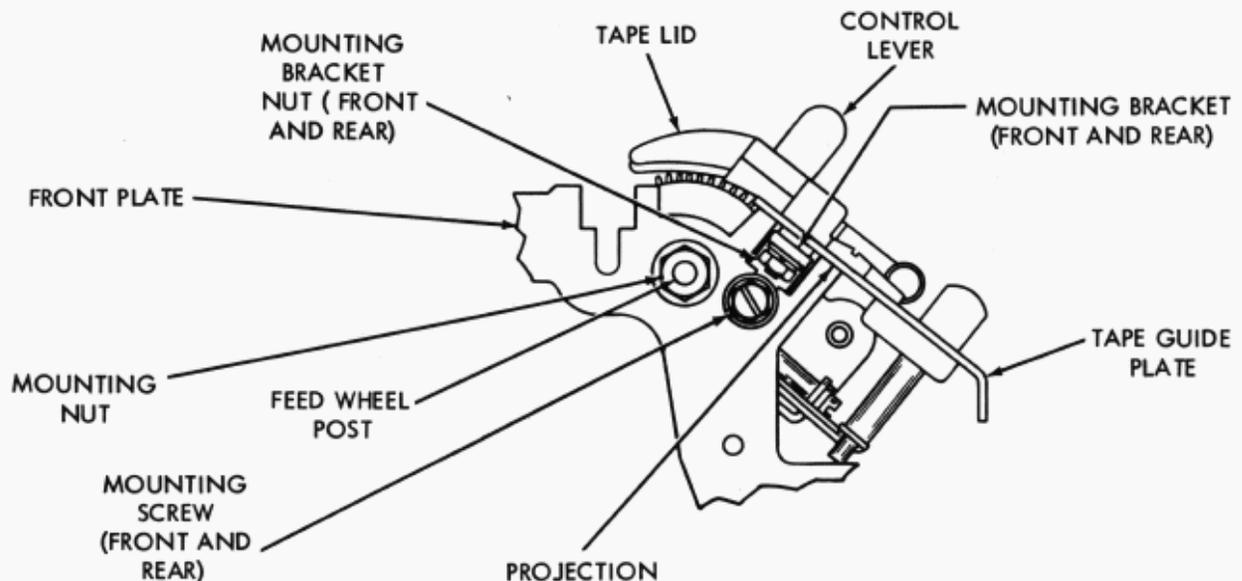
EDGE OF TAPE GUIDE PLATE TO PROJECT OVER FRONT AND REAR PLATES BY EQUAL AMOUNTS AS GAUGED BY EYE.

TO ADJUST

POSITION TAPE GUIDE PLATE.

## NOTE

TIGHT-TAPE BAIL EXTENSION (2.15) MUST BE UNDER TOP PLATE.



SECTION 574-236-700

2.08 Cover and Top Plate Area (continued)

(A) TOP PLATE  
TO CHECK

REMOVE COVER PLATE (SEE RELATED DISASSEMBLY AND REASSEMBLY SECTION).

(1) REQUIREMENT

WITH TAPE LID UNLATCHED,  
MIN FLUSH --- MAX 0.003 INCH  
BELOW TOP SURFACE OF TAPE GUIDE PLATE ALONG WIDTH OF TAPE LID WHEN TOP PLATE IS  
RESTING ON A MINIMUM OF FIVE OF THE SIX PROJECTIONS ON FRONT AND REAR PLATES.  
TO ADJUST

LOOSEN MOUNTING SCREWS AND MOUNTING BRACKET NUTS FRICTION TIGHT. POSITION TOP  
PLATE TO MEET REQUIREMENT (1). TIGHTEN MOUNTING SCREWS. TIGHTEN TAPE GUIDE PLATE  
MOUNTING BRACKET NUTS LEFT FRICTION TIGHT IN ADJUSTMENT 2.07.

NOTE

MOUNTING BRACKET NUTS LOOSENED IN REQUIREMENT (1) ABOVE ARE TIGHTENED AFTER PER-  
FORMING REQUIREMENT (2) BELOW.

(2) REQUIREMENT

WITH TAPE LID UNLATCHED, FEED WHEEL SLOT TO ALIGN WITH SLOT IN TAPE GUIDE PLATE  
SO THAT FEED WHEEL (2.16) ROTATES FREELY WITH CONTROL LEVER IN FREE POSITION.

TO ADJUST

POSITION TOP PLATE TOWARD FRONT OR REAR PLATE. TIGHTEN MOUNTING BRACKET NUTS  
LEFT FRICTION TIGHT IN REQUIREMENT (1) ABOVE.

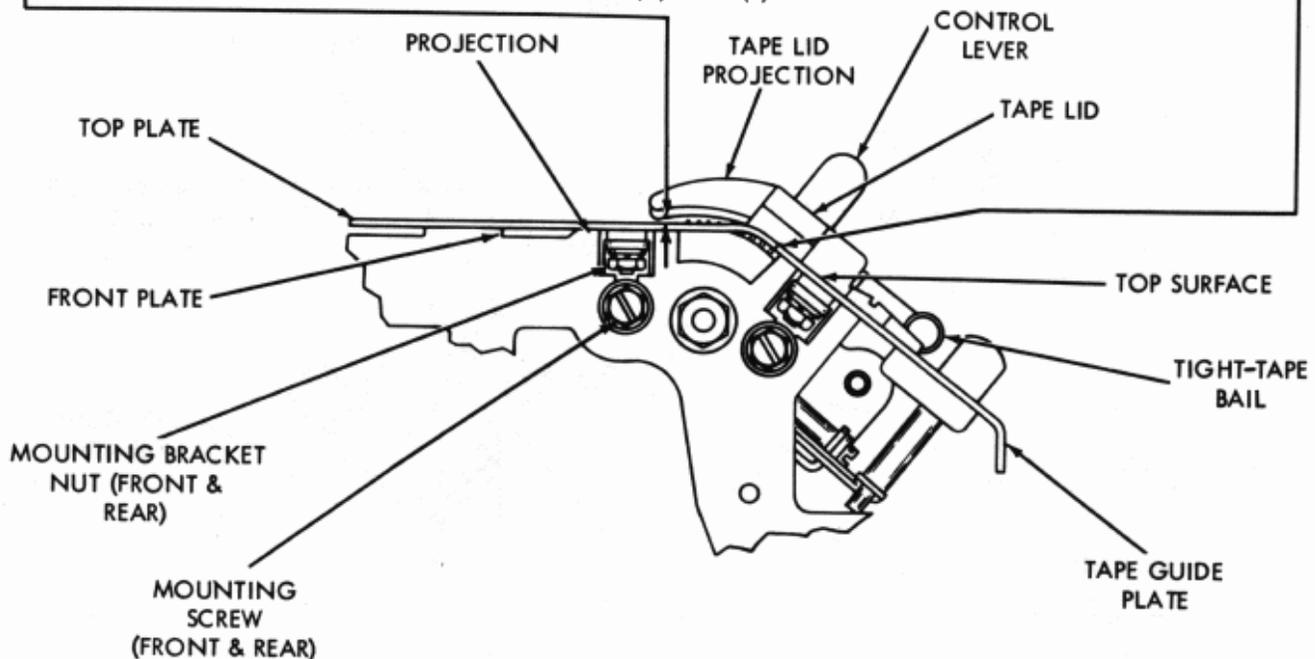
(B) TAPE LID

REQUIREMENT

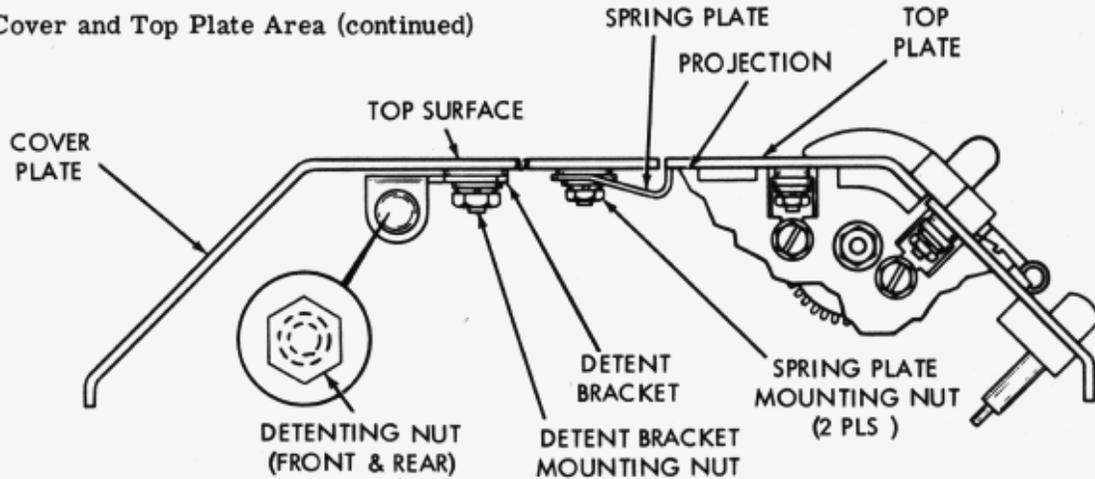
WITH TAPE LID LATCHED,  
MIN 0.010 INCH --- MAX 0.025 INCH  
CLEARANCE BETWEEN TAPE LID PROJECTION AND TOP PLATE WITH PLAY TAKEN UP TOWARD  
TAPE GUIDE PLATE.

TO ADJUST

LOOSEN TAPE LID BEARING BRACKET MOUNTING SCREWS (2.03). POSITION TAPE LID TO MEET  
REQUIREMENT. RECHECK ADJUSTMENTS 2.03(A) AND (B).



2.09 Cover and Top Plate Area (continued)



(A) COVER PLATE

(1) REQUIREMENT

RIGHT EDGE OF COVER PLATE TO BE HELD FLUSH AGAINST LEFT EDGE OF TOP PLATE BY COVER PLATE DETENTING NUTS.

(2) REQUIREMENT

COVER PLATE TO REST FIRMLY AGAINST A MINIMUM OF THREE OF THE FOUR PROJECTIONS ON FRONT AND REAR PLATES.

(3) REQUIREMENT

TOP SURFACE OF COVER AND TOP PLATES TO ALIGN.  
TO ADJUST

LOOSEN DETENTING NUTS ON FRONT AND REAR PLATES FRICTION TIGHT AND MOVE THEM TO THEIR EXTREME LOWER RIGHT POSITION. TIGHTEN NUTS. LOOSEN DETENT BRACKET AND SPRING PLATE MOUNTING NUTS. POSITION COVER PLATE AND MOVE HORIZONTALLY TO MEET ABOVE REQUIREMENTS. REFINE LOCATION OF DETENTING NUTS IF COVER PLATE DOES NOT SEAT AS REQUIRED WHEN PLUNGERS DETENT.

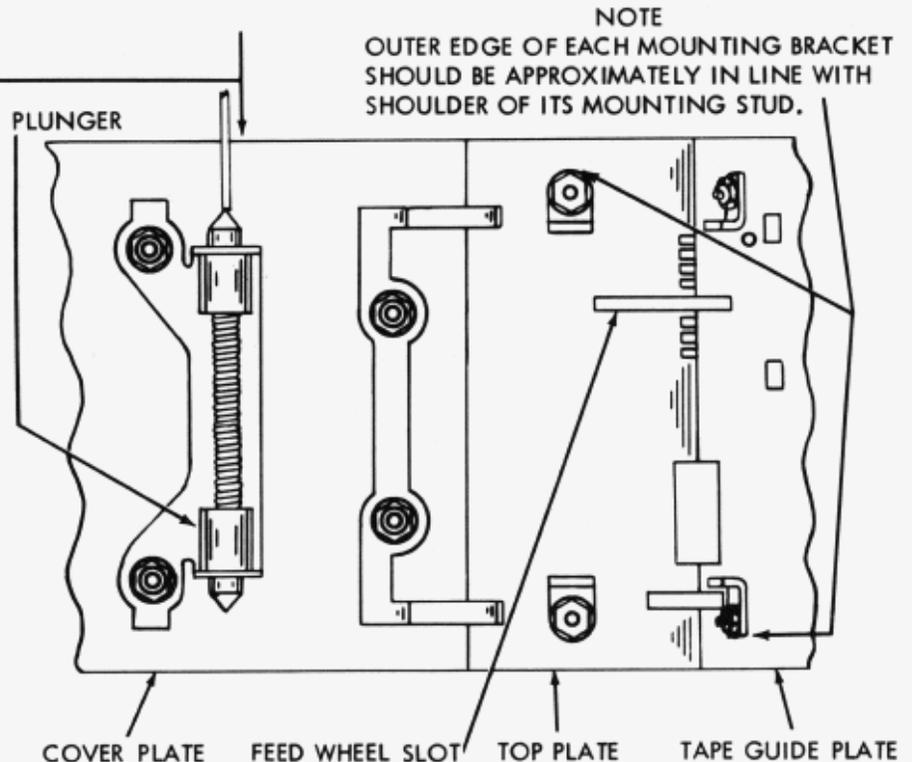
(B) COVER PLATE DETENT SPRING

REQUIREMENT

MIN 28 OZ ---  
MAX 48 OZ  
TO START PLUNGER MOVING.

NOTE

1. OUTER EDGE OF EACH MOUNTING BRACKET TO BE APPROXIMATELY IN LINE WITH SHOULDER OF ITS MOUNTING STUD AND PARALLEL TO EDGE OF PLATE.
2. COVER, TOP, AND TAPE GUIDE PLATES TO BE APPROXIMATELY FLUSH AND IN LINE WITH EACH OTHER.





## 2.11 Tape-Out Contact Assembly (continued)

(A) TAPE-OUT PIN SPRING

TO CHECK

PLACE CONTROL LEVER (2.06) IN RUN POSITION.

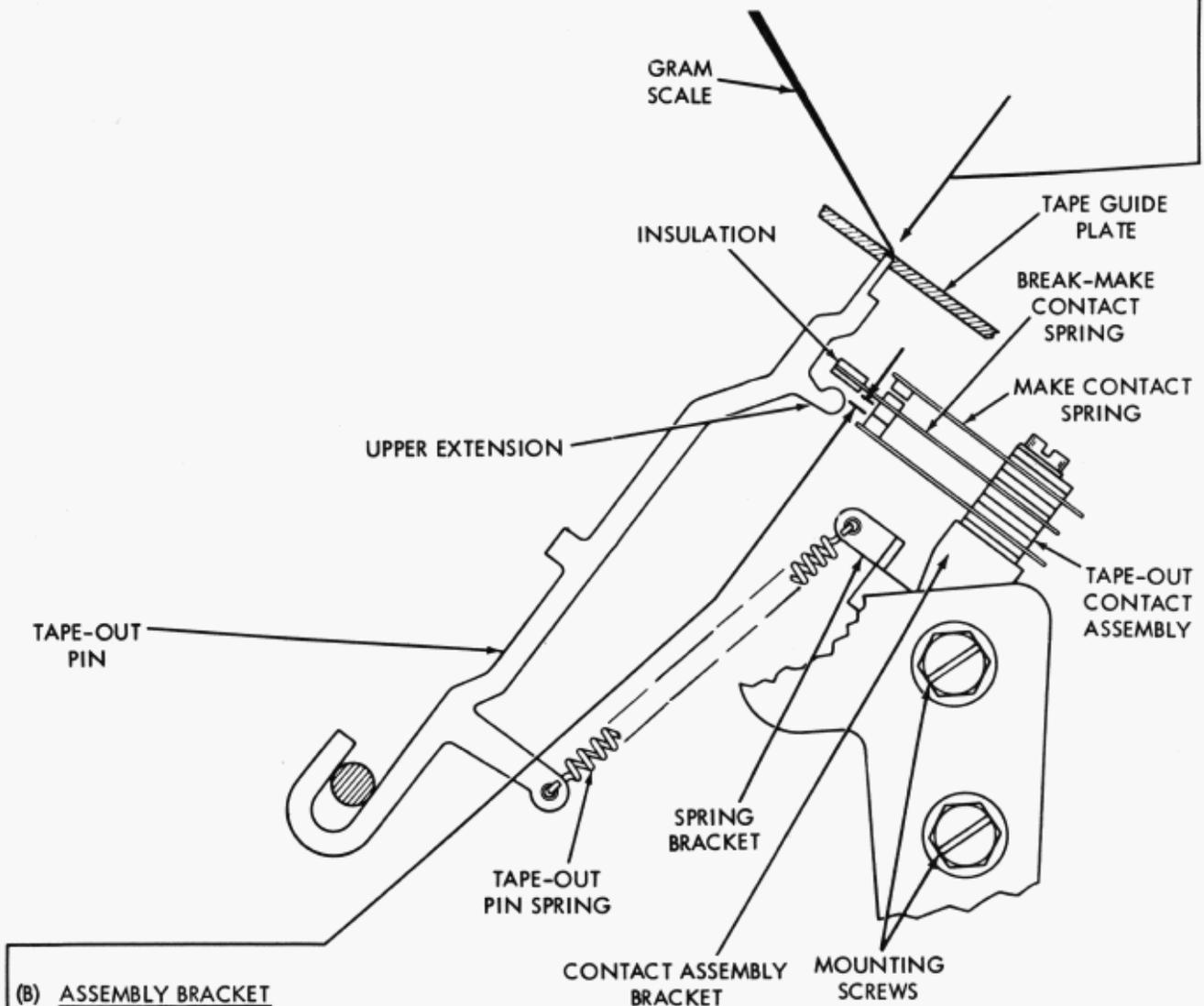
REQUIREMENT

MIN 38 GRAMS --- MAX 45 GRAMS

TO MOVE TAPE-OUT PIN TO A POSITION FLUSH WITH TAPE GUIDE PLATE.

TO ADJUST

LOOSEN LOWER MOUNTING SCREW OF CONTACT ASSEMBLY BRACKET. POSITION SPRING BRACKET.

(B) ASSEMBLY BRACKET

TO CHECK

INSERT TAPE UNDER TAPE LID (2.07) TO HOLD TAPE-OUT PIN DOWN.

REQUIREMENT

MIN 0.006 INCH --- MAX 0.020 INCH

CLEARANCE BETWEEN TAPE-OUT PIN UPPER EXTENSION AND UNDERSIDE OF INSULATION ON BREAK-MAKE CONTACT SPRING.

TO ADJUST

LOOSEN CONTACT ASSEMBLY BRACKET MOUNTING SCREWS AND ADJUST BRACKET UNTIL REQUIREMENT IS MET.

2.12 Tape-Out Pin Mechanism

(A) STOP ARM  
TO CHECK

PLACE CONTROL LEVER (2.06) IN STOP POSITION.

REQUIREMENT

TAPE-OUT PIN TO BE  
MIN FLUSH --- MAX 0.010 INCH  
BELOW SURFACE OF TAPE GUIDE PLATE.

TO ADJUST

LOOSEN STOP ARM SCREW. POSITION STOP ARM. RECHECK REQUIREMENT.

(B) TAPE-OUT BAIL

TO CHECK

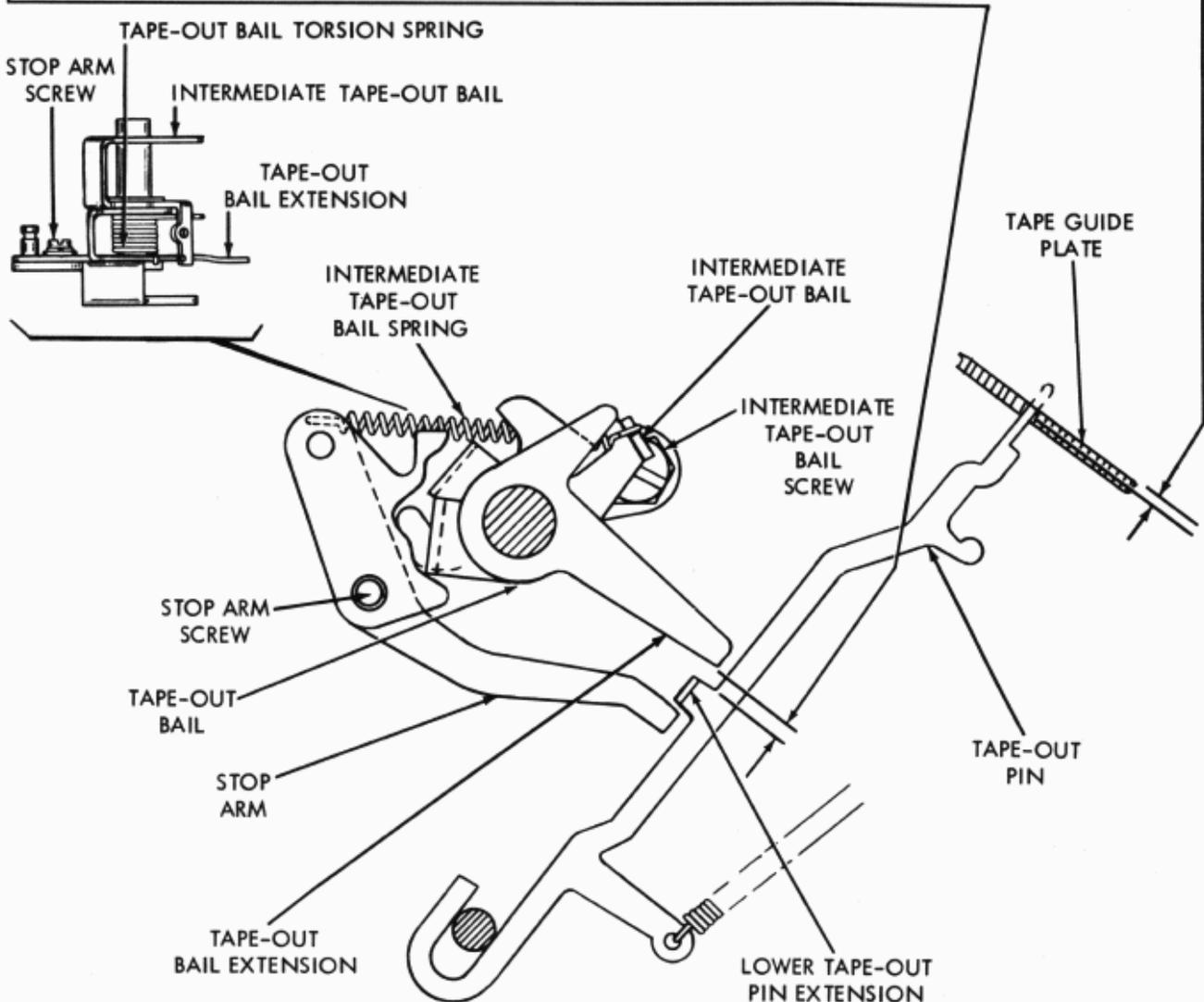
PLACE CONTROL LEVER (2.06) IN RUN POSITION.

REQUIREMENT

MIN 0.055 INCH  
CLEARANCE BETWEEN LOWER TAPE-OUT PIN EXTENSION AND TAPE-OUT BAIL EXTENSION.

TO ADJUST

LOOSEN INTERMEDIATE TAPE-OUT BAIL SCREW. POSITION TAPE-OUT BAIL. RECHECK REQUIREMENT 2.12(A).



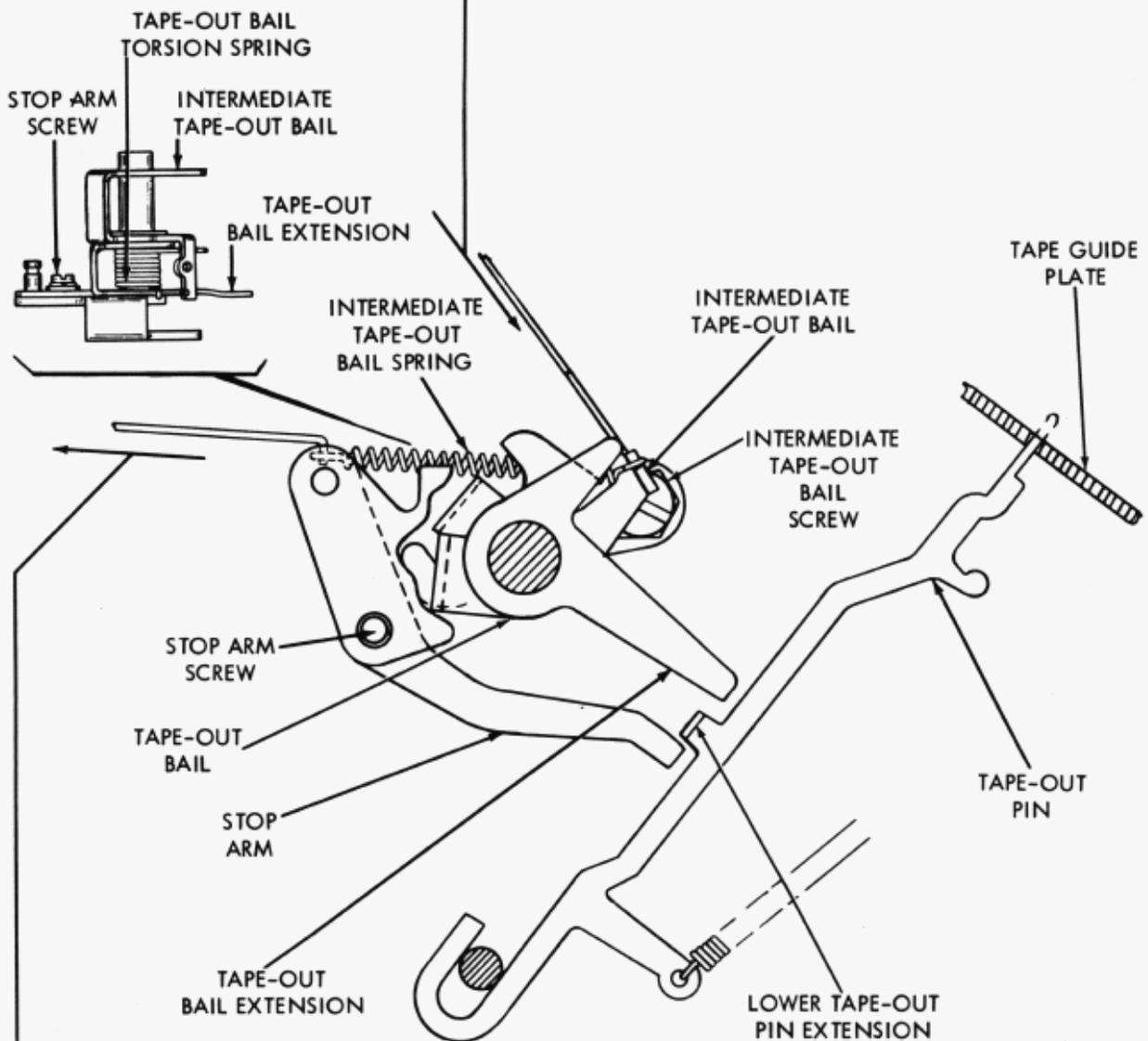
## 2.13 Tape-Out Pin Mechanism (continued)

**(A) TAPE-OUT TORSION SPRING**

TO CHECK

CONTROL LEVER (2.06) IN STOP POSITION, UNHOOK ONE END OF INTERMEDIATE TAPE-OUT BAIL SPRING.

REQUIREMENT

MIN 3 OZS. --- MAX 5-1/2 OZS.  
TO START INTERMEDIATE TAPE-OUT BAIL MOVING.**(B) INTERMEDIATE TAPE-OUT BAIL SPRING**

TO CHECK

CONTROL LEVER (2.06) IN RUN POSITION, UNHOOK INTERMEDIATE TAPE-OUT BAIL SPRING AT POST END.

REQUIREMENT

MIN 3 OZS. --- MAX 5 OZS.  
TO PULL SPRING TO INSTALLED LENGTH.

2.14 Tight-Tape Mechanism

(A) CONTROL CONTACT ASSEMBLY BRACKET

TO CHECK

PLACE CONTROL LEVER (2.06) IN RUN POSITION.

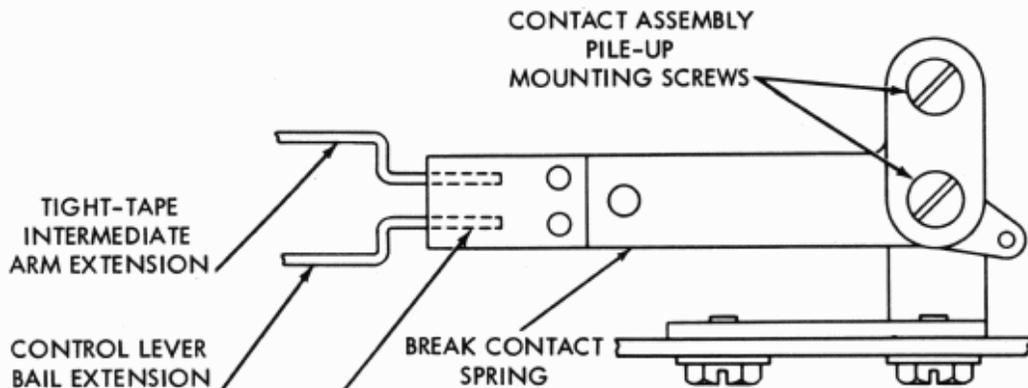
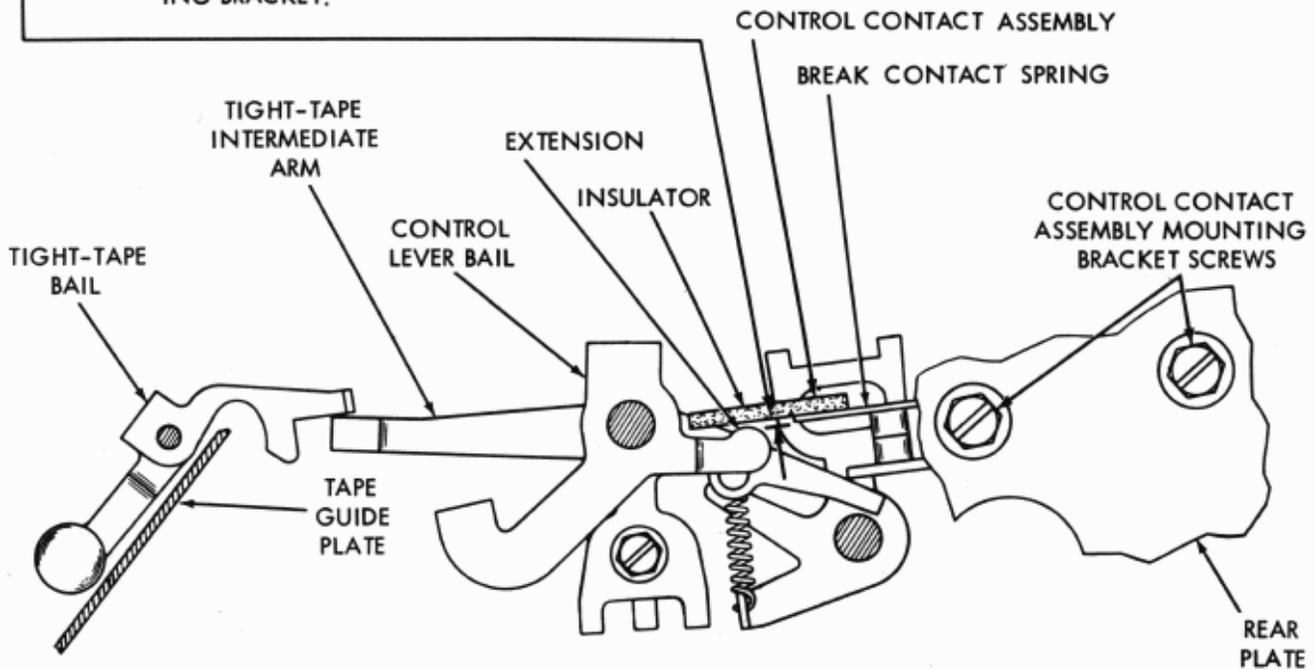
REQUIREMENT

MIN 0.006 INCH --- MAX 0.015 INCH

CLEARANCE BETWEEN EXTENSION ON CONTROL LEVER BAIL AND INSULATOR ON BREAK CONTACT SPRING.

TO ADJUST

LOOSEN CONTROL CONTACT ASSEMBLY MOUNTING BRACKET SCREWS AND POSITION MOUNTING BRACKET.



(B) BREAK CONTACT SPRING

REQUIREMENT

INSULATOR ON BREAK CONTACT SPRING TO BE FULLY ENGAGED BY CONTROL LEVER BAIL EXTENSION AND TIGHT-TAPE INTERMEDIATE ARM EXTENSION.

TO ADJUST

LOOSEN CONTACT ASSEMBLY PILE-UP MOUNTING SCREWS AND POSITION BREAK CONTACT SPRING.

## 2.15 Tight-Tape Mechanism (continued)

**(A) CONTROL CONTACT SPRING**

TO CHECK

PLACE CONTROL LEVER (2.06) IN RUN POSITION.

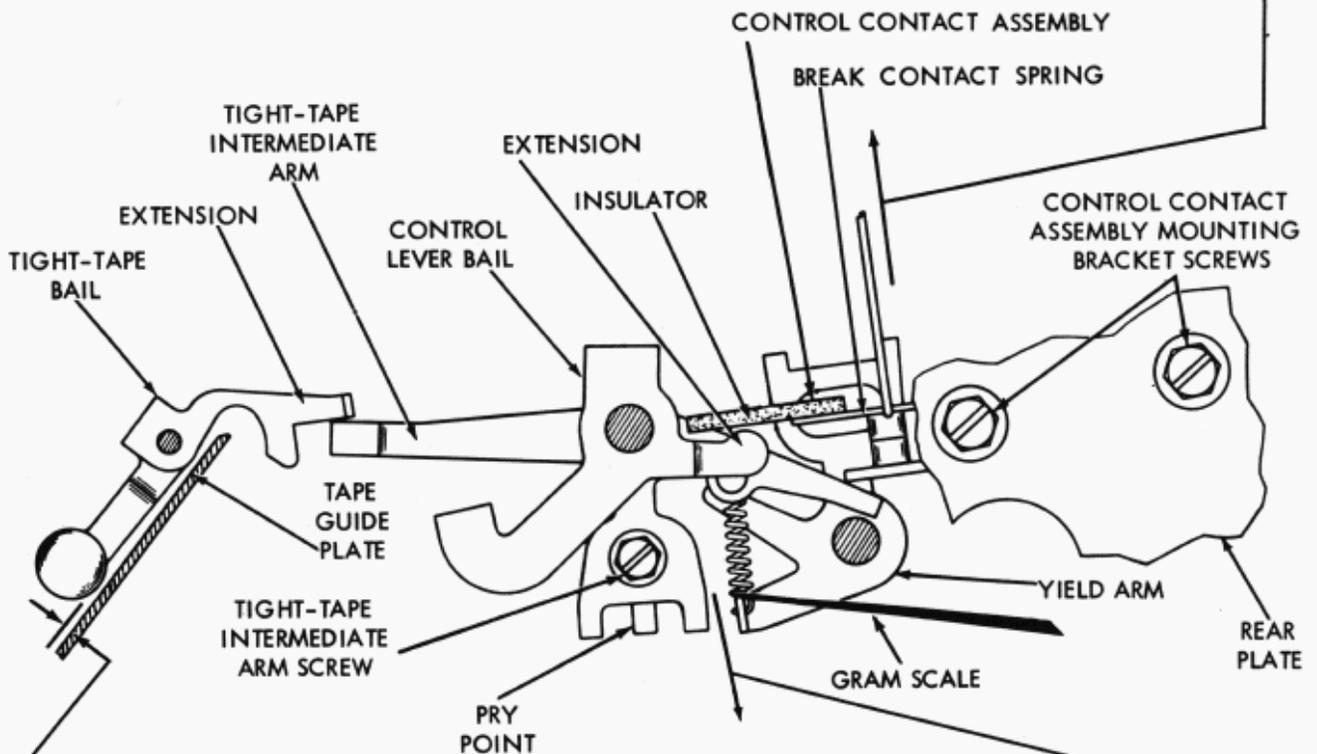
REQUIREMENT

MIN 3 OZS. --- MAX 4 OZS.

TO SEPARATE CONTACTS.

TO ADJUST

BEND BREAK CONTACT SPRING WITH TP110445 SPRING BENDER TO MEET REQUIREMENT. RE-CHECK CONTROL CONTACT ASSEMBLY BRACKET AND TIGHT-TAPE INTERMEDIATE ARM ADJUSTMENTS.

**(B) INTERMEDIATE ARM**

TO CHECK

PLACE CONTROL LEVER (2.06) IN RUN POSITION.

REQUIREMENT

CONTACTS OF CONTROL CONTACT ASSEMBLY TO OPEN WHEN TIGHT-TAPE BAIL RAISED,

MIN 0.045 INCH --- MAX 0.075 INCH

AWAY FROM TAPE GUIDE PLATE.

TO ADJUST

LOOSEN TIGHT-TAPE INTERMEDIATE ARM SCREW AND POSITION TIGHT-TAPE INTERMEDIATE ARM USING PRY POINT.

**(C) INTERMEDIATE ARM SPRING**

TO CHECK

PLACE CONTROL LEVER (2.06) IN RUN POSITION.

REQUIREMENT

MIN 20 GRAMS --- MAX 40 GRAMS

TO START YIELD ARM MOVING.

2.16 Main Bail Mechanism

(A) TRANSFER LEVER GUIDE POST  
TO CHECK

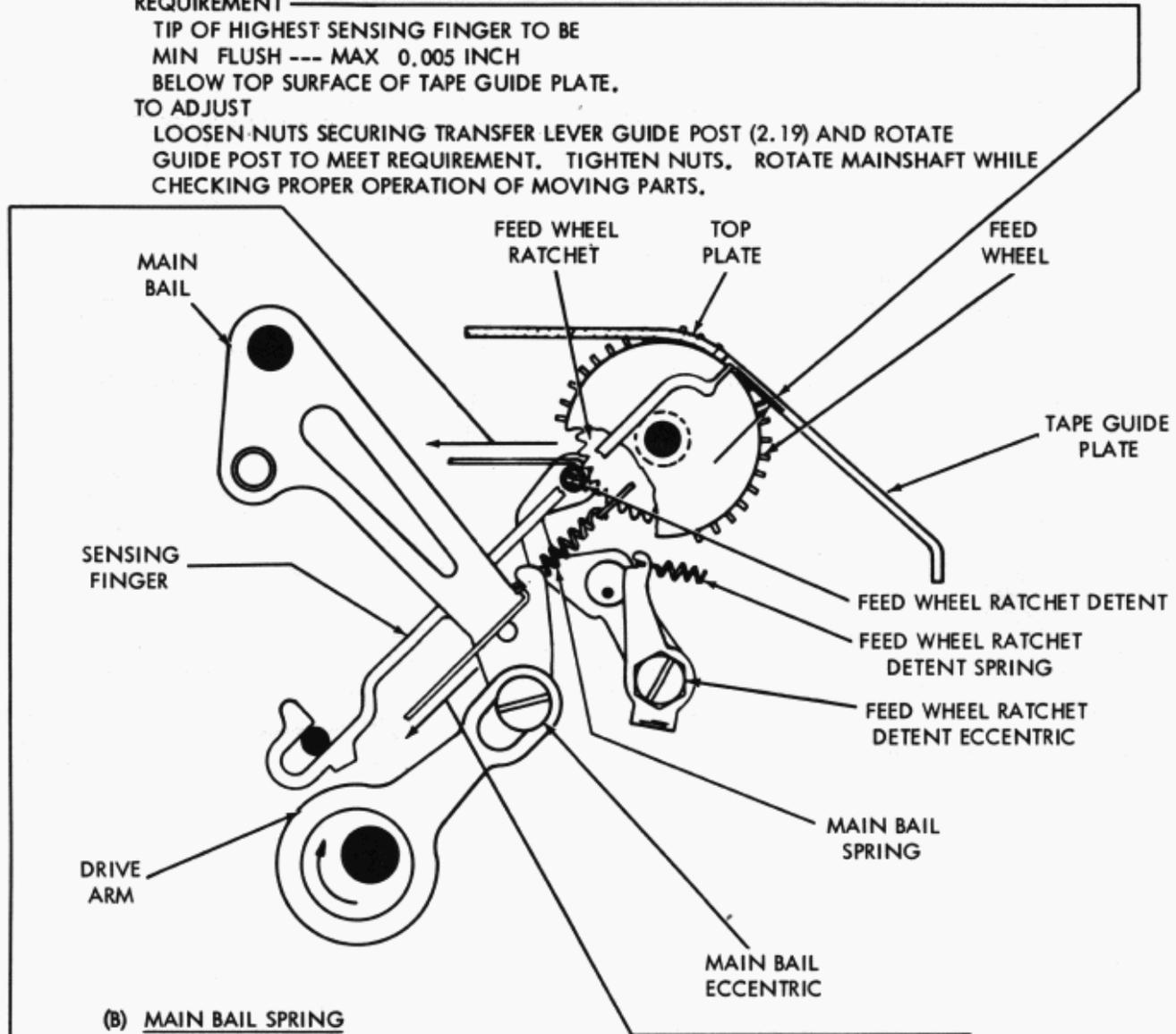
PLACE MAINSHAFT IN STOP POSITION AND DISENGAGE CLUTCH.

REQUIREMENT

TIP OF HIGHEST SENSING FINGER TO BE  
MIN FLUSH --- MAX 0.005 INCH  
BELOW TOP SURFACE OF TAPE GUIDE PLATE.

TO ADJUST

LOOSEN NUTS SECURING TRANSFER LEVER GUIDE POST (2.19) AND ROTATE  
GUIDE POST TO MEET REQUIREMENT. TIGHTEN NUTS. ROTATE MAINSHAFT WHILE  
CHECKING PROPER OPERATION OF MOVING PARTS.



(B) MAIN BAIL SPRING  
TO CHECK

CLUTCH DISENGAGED, UNHOOK LOWER END OF MAIN BAIL SPRING.

REQUIREMENT

MIN 6 OZ --- MAX 10 OZ  
TO PULL MAIN BAIL SPRING TO INSTALLED LENGTH.

(C) FEED WHEEL RATCHET DETENT SPRING  
TO CHECK

WITH MAINSHAFT IN STOP POSITION, HOLD FEED PAWL (2.18) AWAY FROM  
FEED WHEEL RATCHET.

REQUIREMENT

MIN 8 OZ --- MAX 13 OZ  
TO START FEED WHEEL RATCHET DETENT MOVING.

2.17 Tape Sensing Mechanism

(A) FEED WHEEL DETENT TO CHECK

SENSING FINGERS DOWN, TAPE LID (2.06(B)) UNLATCHED, HIGH PART OF FEED WHEEL RATCHET DETENT ECCENTRIC (2.16) TOWARD RIGHT, PLACE A NEW PIECE OF LETTERS PERFORATED TAPE ON FEED WHEEL. TAKE UP PLAY IN THE TAPE LIGHTLY TOWARD RIGHT.

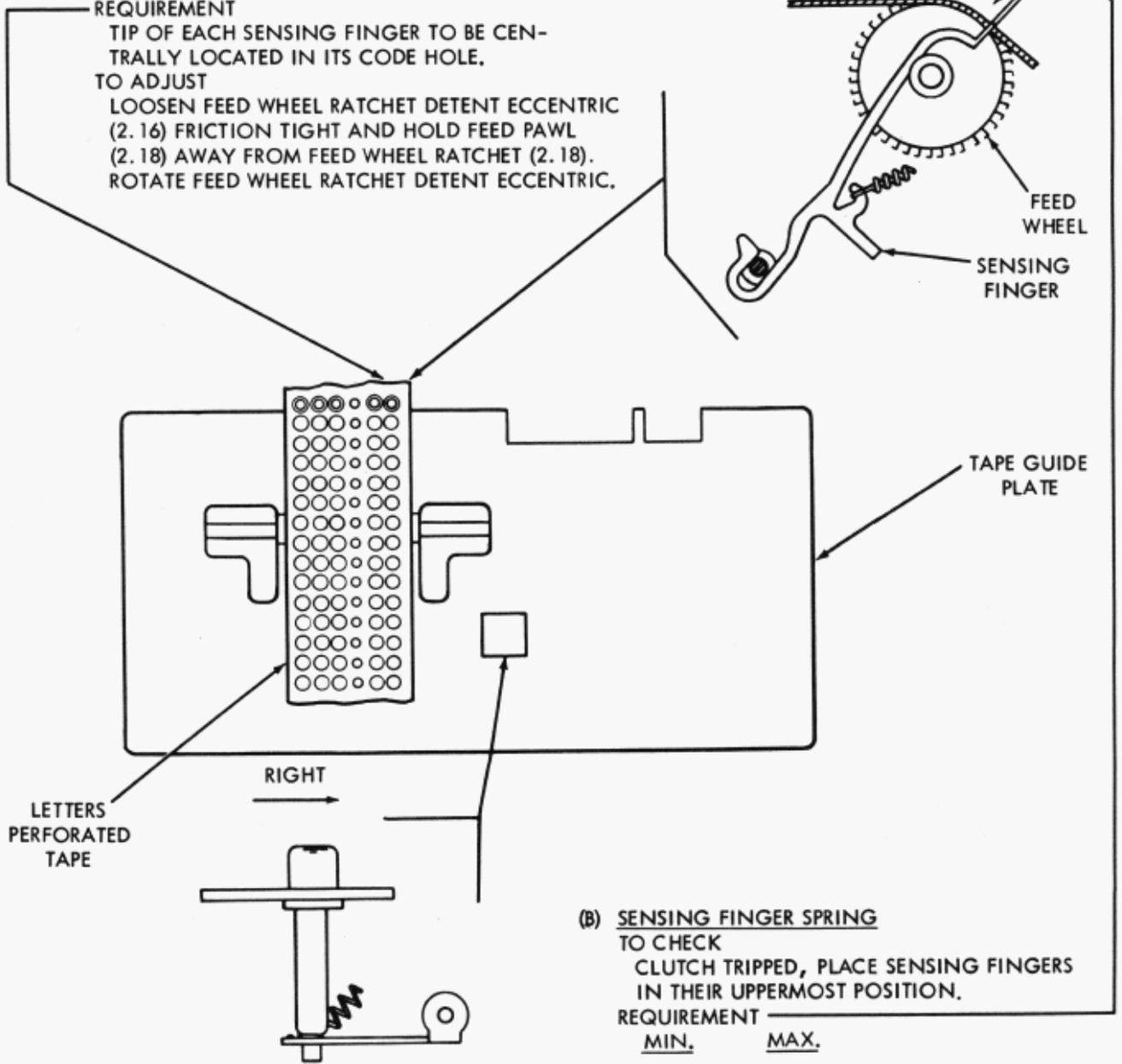
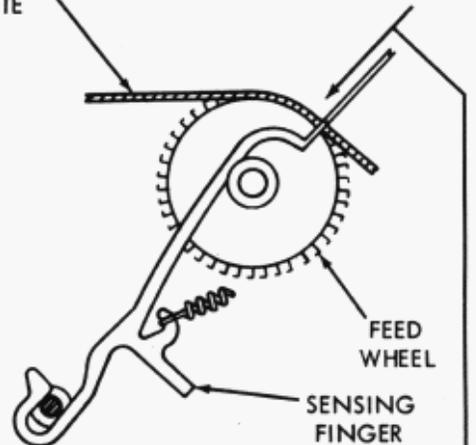
REQUIREMENT

TIP OF EACH SENSING FINGER TO BE CENTRALLY LOCATED IN ITS CODE HOLE.

TO ADJUST

LOOSEN FEED WHEEL RATCHET DETENT ECCENTRIC (2.16) FRICTION TIGHT AND HOLD FEED PAWL (2.18) AWAY FROM FEED WHEEL RATCHET (2.18). ROTATE FEED WHEEL RATCHET DETENT ECCENTRIC.

TAPE GUIDE PLATE



(B) SENSING FINGER SPRING TO CHECK

CLUTCH TRIPPED, PLACE SENSING FINGERS IN THEIR UPPERMOST POSITION.

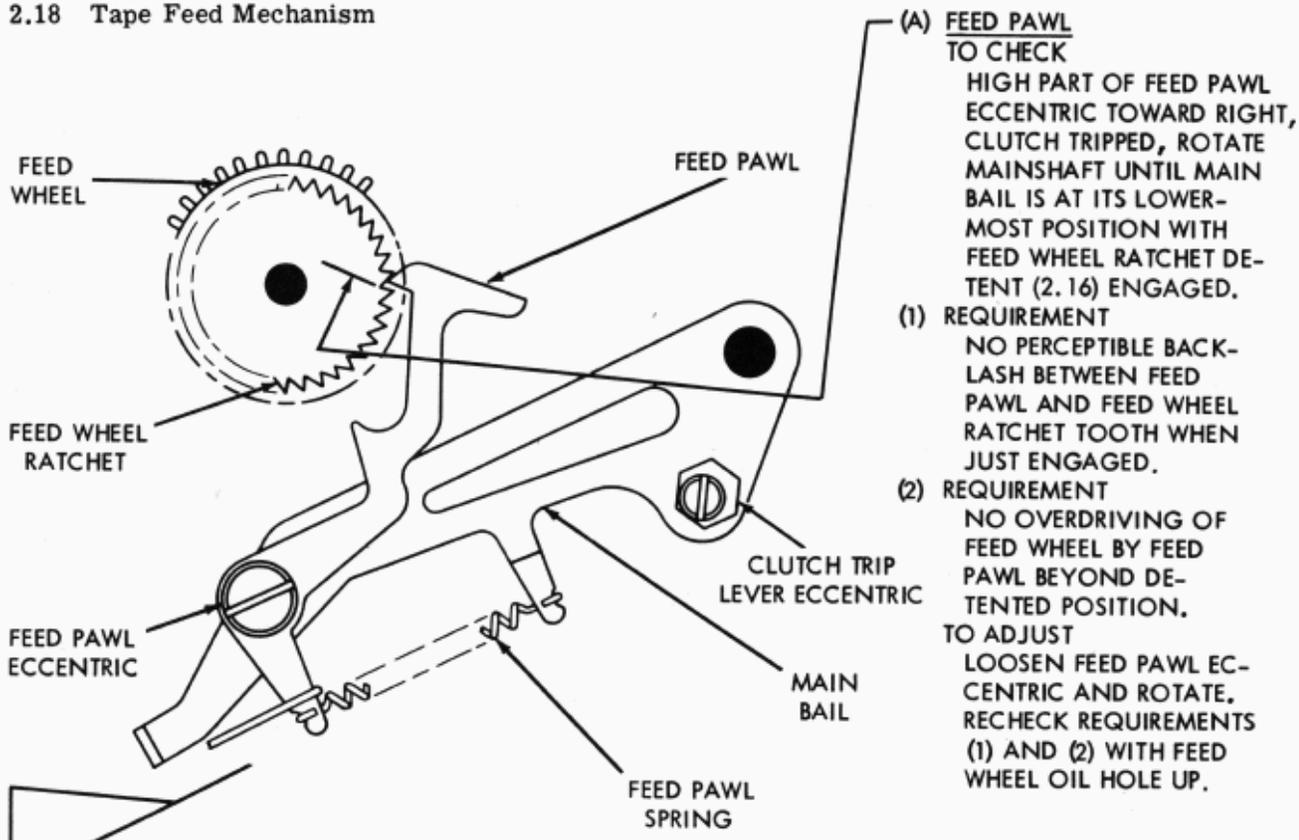
REQUIREMENT

| MIN. | MAX. |
|------|------|
| 2 OZ | 3 OZ |

2 OZ --- 3 OZ

TO MOVE SENSING FINGERS FLUSH WITH TAPE GUIDE PLATE.

2.18 Tape Feed Mechanism



(A) FEED PAWL TO CHECK  
 HIGH PART OF FEED PAWL ECCENTRIC TOWARD RIGHT, CLUTCH TRIPPED, ROTATE MAINSHAFT UNTIL MAIN BAIL IS AT ITS LOWERMOST POSITION WITH FEED WHEEL RATCHET DETENT (2.16) ENGAGED.

(1) REQUIREMENT  
 NO PERCEPTIBLE BACKLASH BETWEEN FEED PAWL AND FEED WHEEL RATCHET TOOTH WHEN JUST ENGAGED.

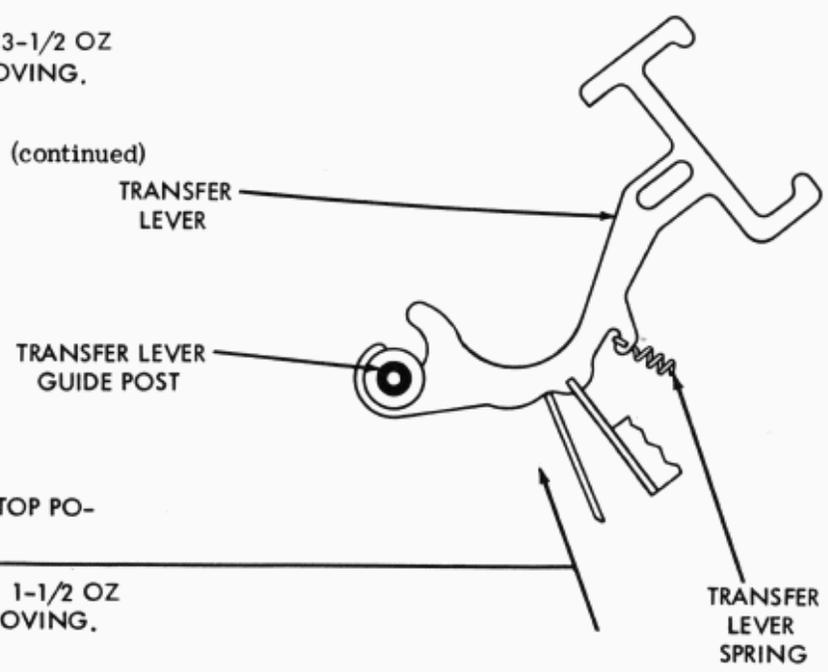
(2) REQUIREMENT  
 NO OVERDRIVING OF FEED WHEEL BY FEED PAWL BEYOND DENTED POSITION.

TO ADJUST  
 LOOSEN FEED PAWL ECCENTRIC AND ROTATE. RECHECK REQUIREMENTS (1) AND (2) WITH FEED WHEEL OIL HOLE UP.

(B) FEED PAWL SPRING TO CHECK  
 PLACE MAINSHAFT IN STOP POSITION.

REQUIREMENT  
 MIN 2 OZ --- MAX 3-1/2 OZ TO START FEED PAWL MOVING.

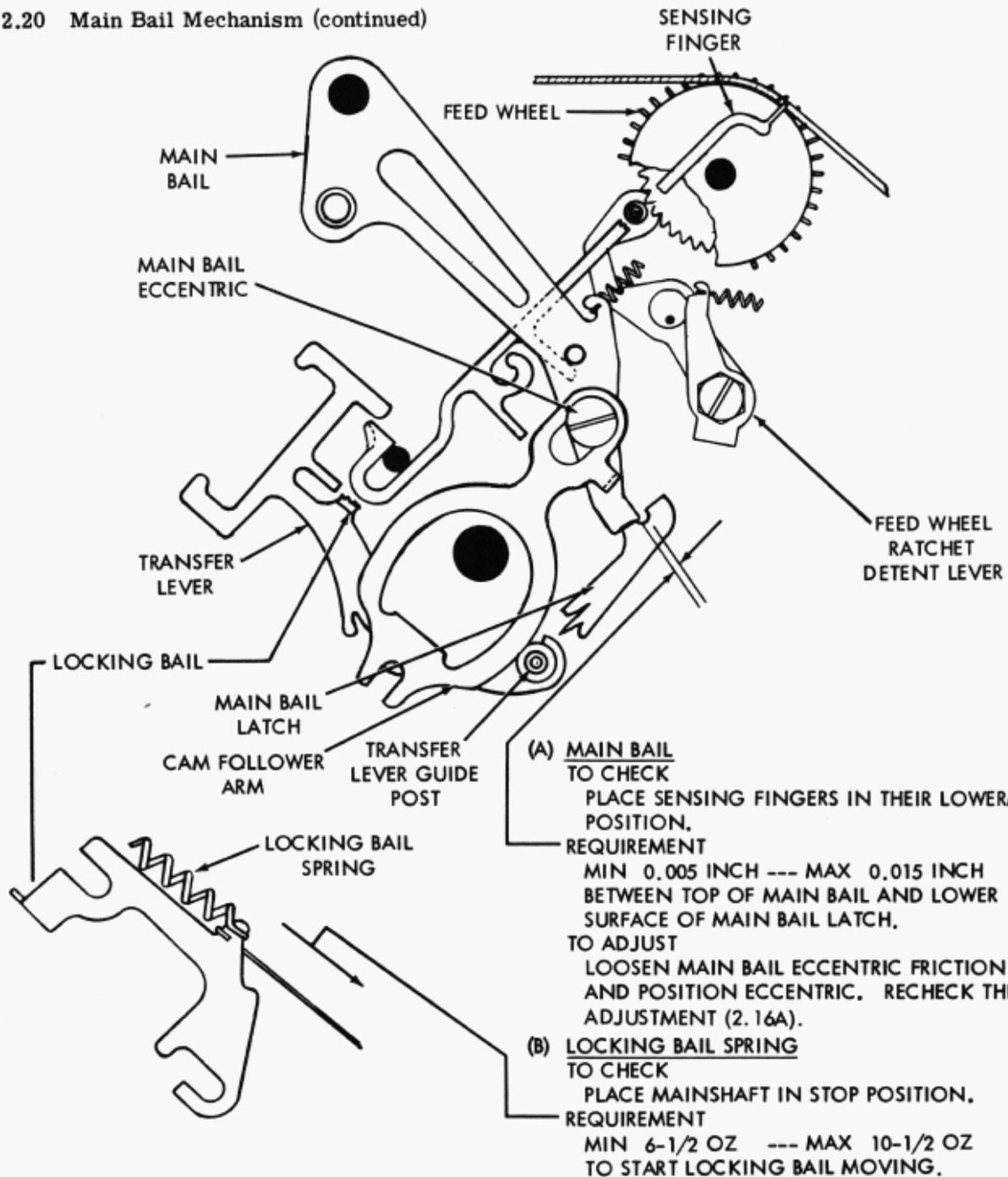
2.19 Tape Sensing Mechanism (continued)



TRANSFER LEVER SPRING TO CHECK  
 PLACE MAINSHAFT IN STOP POSITION.

REQUIREMENT  
 MIN 1/2-OZ --- MAX 1-1/2 OZ TO START EACH LEVER MOVING.

## 2.20 Main Bail Mechanism (continued)



2.21 Clutch Magnet Assembly

(A) ARMATURE BAIL HINGE

TO CHECK

ARMATURE IN ENERGIZED POSITION.

REQUIREMENT

ARMATURE TO CONTACT CORE FACE OF TOP MAGNET WITH

MIN SOME --- MAX 0.004 INCH

CLEARANCE BETWEEN ARMATURE AND CORE FACE OF BOTTOM

MAGNET AT POINT OF LEAST CLEARANCE.

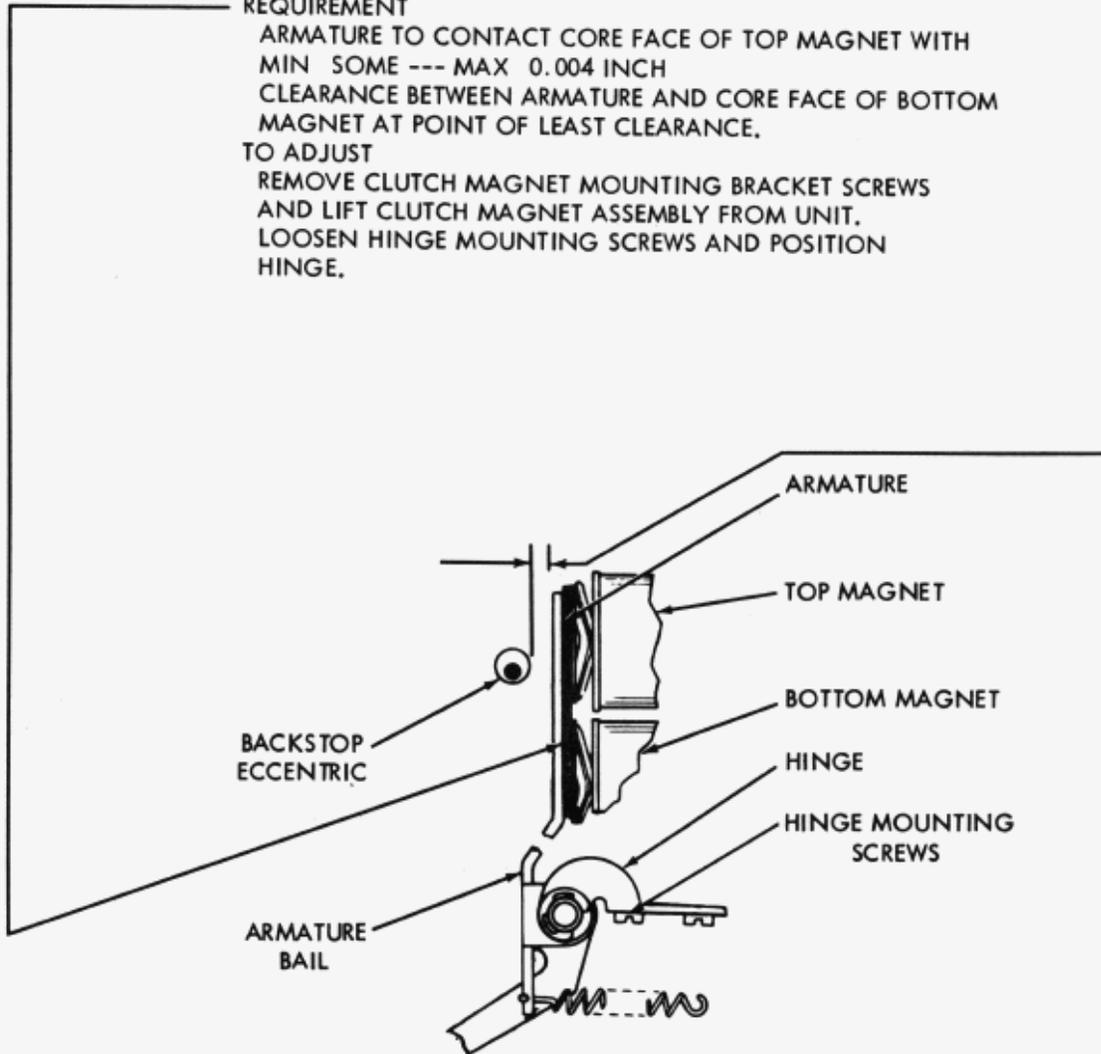
TO ADJUST

REMOVE CLUTCH MAGNET MOUNTING BRACKET SCREWS

AND LIFT CLUTCH MAGNET ASSEMBLY FROM UNIT.

LOOSEN HINGE MOUNTING SCREWS AND POSITION

HINGE.



(B) BACKSTOP ECCENTRIC

TO CHECK

WITH HIGH PART OF BACK STOP ECCENTRIC TOWARDS

TOP OF UNIT, HOLD ARMATURE IN ENERGIZED POSI-

TION.

REQUIREMENT

MIN 0.045 INCH --- MAX 0.055 INCH

CLEARANCE BETWEEN ARMATURE BAIL AND BACKSTOP ECCENTRIC.

TO ADJUST

LOOSEN BACKSTOP ECCENTRIC AND POSITION.

## 2.22 Clutch Magnet Assembly (continued)

(A) ASSEMBLYTO CHECK

WITH CLUTCH MAGNET ASSEMBLY REPLACED INTO UNIT IN ITS LOWEST POSITION AND CLUTCH MAGNET BRACKET MOUNTING SCREWS FRICTION TIGHT, DIS-ENGAGE CLUTCH.

REQUIREMENT

MIN 0.007 INCH --- MAX 0.015 INCH CLEARANCE BETWEEN END OF ARMATURE BAIL EXTENSION AND MAIN BAIL LATCH.

TO ADJUST

POSITION CLUTCH MAGNET ASSEMBLY AT PRY POINT. RECHECK REQUIREMENT.

NOTE

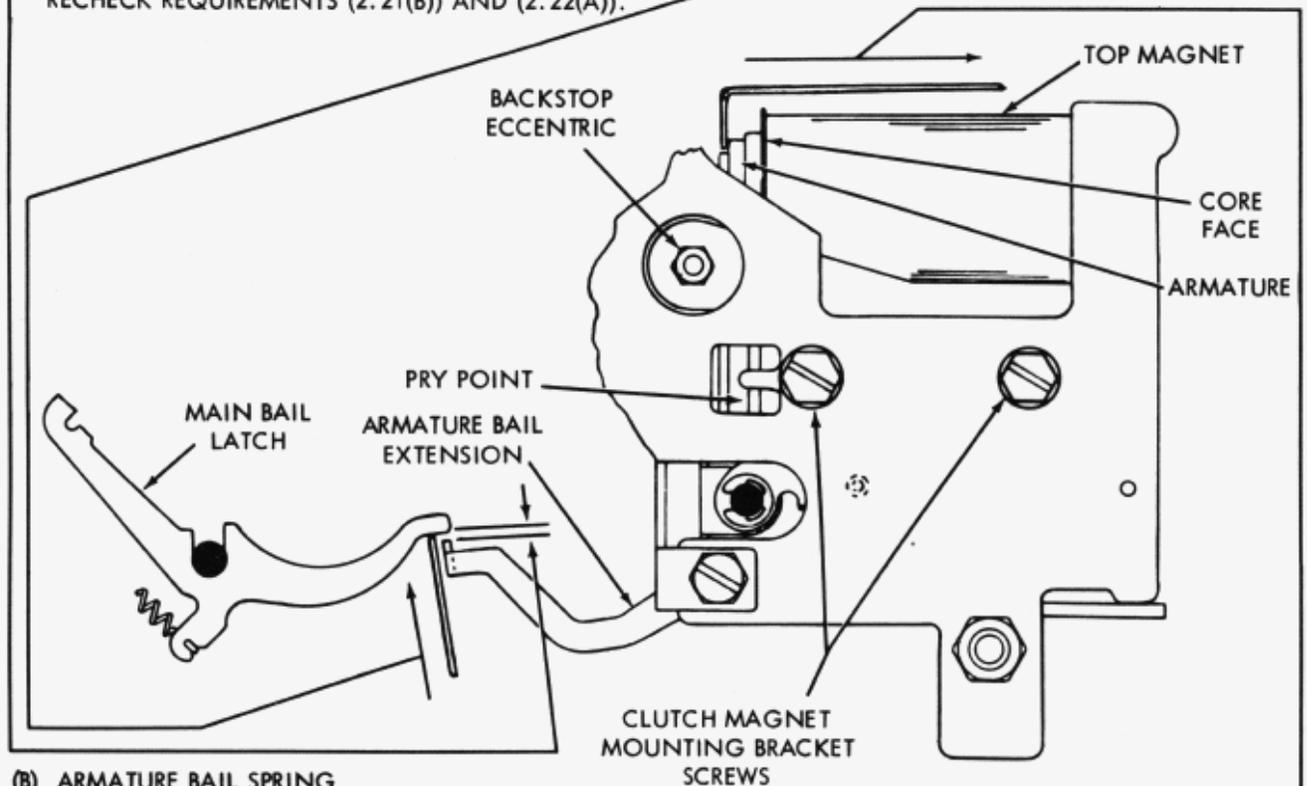
IF AC POWER IS USED, MAKE A CHECK OF ARMATURE CHATTER. IT MUST BE A MINIMUM. IF EXCESSIVE CHATTER IS PRESENT, REFINE REQUIREMENT (2.21(A)) AND RECHECK REQUIREMENTS (2.21(B)) AND (2.22(A)).

(C) MAIN BAIL LATCH SPRINGTO CHECK

RELEASE MAIN BAIL LATCH.

REQUIREMENT

MIN 3/4 OZ --- MAX 2 OZ TO START MAIN BAIL LATCH MOVING.

(B) ARMATURE BAIL SPRINGTO CHECK

ARMATURE IN DE-ENERGIZED POSITION, HOLD MAIN BAIL LATCH AWAY FROM ARMATURE BAIL EXTENSION.

REQUIREMENT

MIN 1 OZ --- MAX 2 OZ

TO START ARMATURE MOVING.

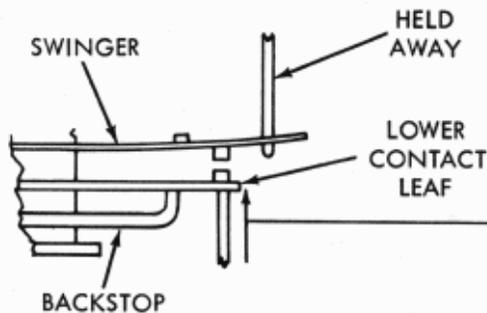
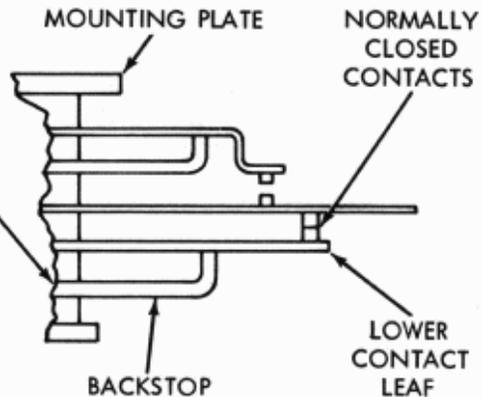
2.23 Code Reading Contacts

Initial Adjustments

NOTE

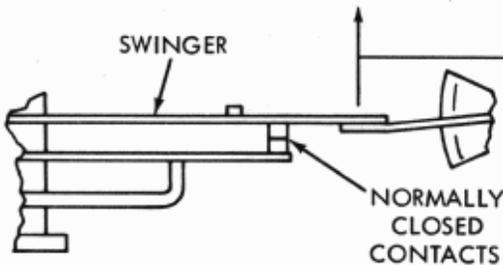
INITIAL ADJUSTMENTS SHOULD BE MADE WITH THE CODE READING CONTACT ASSEMBLY REMOVED FROM THE TRANSMITTER UNIT.

- (A) NORMALLY CLOSED CONTACTS - BACKSTOP REQUIREMENT  
 THE LOWER CONTACT LEAVES FOR ALL LEVELS SHOULD BE PARALLEL TO THE MOUNTING PLATE AND IN LINE WITH ONE ANOTHER.  
 TO ADJUST  
 BEND BACKSTOP TO MEET REQUIREMENT.

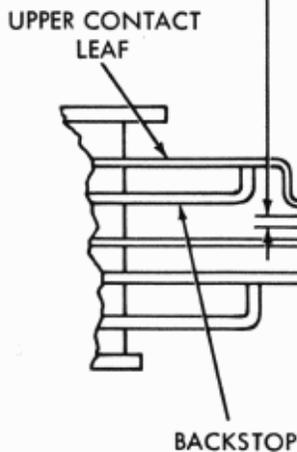


- (B) NORMALLY CLOSED CONTACTS - SPRING TENSION REQUIREMENT  
 (1) WITH SWINGER HELD AWAY  
 MIN 2 OZ --- MAX 6 OZ  
 TO MOVE LOWER CONTACT LEAF AWAY FROM BACKSTOP.

TO ADJUST  
 BEND LOWER LEAF. IF IT IS NECESSARY TO BEND BACKSTOP TO OBTAIN REQUIRED TENSION, REPOSITION BACKSTOP TO MEET NORMALLY CLOSED CONTACTS - BACKSTOP REQUIREMENT.  
 (2) MIN 30 GRAMS --- MAX 40 GRAMS  
 TO OPEN NORMALLY CLOSED CONTACTS.  
 TO ADJUST  
 BEND SWINGER.



- (C) NORMALLY OPEN CONTACTS - BACKSTOP REQUIREMENT  
 MIN 0.010 INCH --- MAX 0.015 INCH  
 GAP BETWEEN NORMALLY OPEN CONTACTS.  
 TO ADJUST  
 BEND ASSOCIATED BACKSTOP TO MEET REQUIREMENT.



- (D) NORMALLY OPEN CONTACTS - SPRING TENSION REQUIREMENT  
 MIN 30 GRAMS --- MAX 40 GRAMS  
 TO MOVE NORMALLY OPEN CONTACTS AWAY FROM BACKSTOP.  
 TO ADJUST  
 BEND UPPER CONTACT LEAF. IF IT IS NECESSARY TO BEND BACKSTOP TO OBTAIN REQUIRED TENSION, REPOSITION BACKSTOP TO MEET REQUIREMENT (2.23(C)).

## 2.24 Code Reading Contacts (continued)

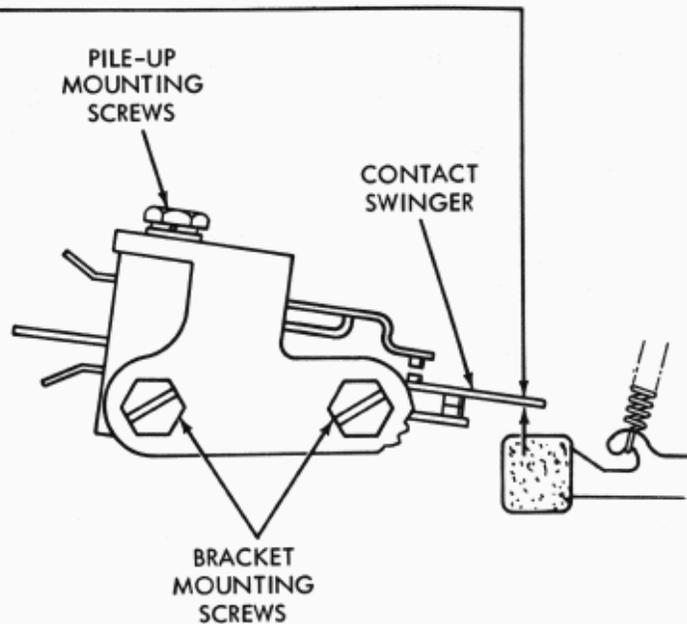
## Secondary Adjustments

## NOTE

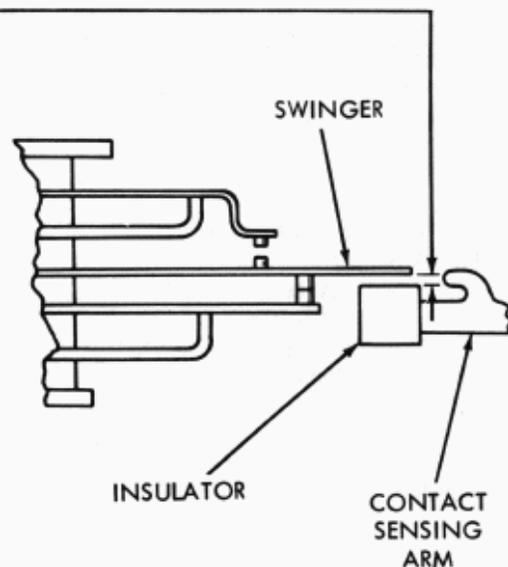
THE SECONDARY ADJUSTMENTS SHOULD BE MADE WITH THE CODE READING CONTACT ASSEMBLY INSTALLED IN THE TRANSMITTER, WITH THE CONTACT ASSEMBLY BRACKET APPROXIMATELY CENTERED IN ITS ADJUSTMENT RANGE.

(A) CONTACT ASSEMBLY  
REQUIREMENT

THE SWINGER OF EACH CONTACT PILE-UP SHOULD BE ALIGNED WITH ITS ASSOCIATED SENSING ARM, AS GAGED BY EYE.  
TO ADJUST  
LOOSEN THE SCREWS WHICH MOUNT THE CONTACT ASSEMBLY TO THE CONTACT BRACKET, AND POSITION THE ASSEMBLY TO MEET REQUIREMENT.

(B) CONTACT BRACKET  
REQUIREMENT

WITH THE BLANK COMBINATION SELECTED AND THE UP-STOP POST OUT OF THE WAY  
MIN 0.015 INCH --- MAX 0.025 INCH  
GAP BETWEEN CONTACT ASSEMBLY SWINGERS AND INSULATOR ON CONTACT SENSING ARM.  
TO ADJUST  
LOOSEN THE CONTACT BRACKET MOUNTING SCREWS (2.24(A)) AND POSITION THE BRACKET TO MEET REQUIREMENTS.



SECTION 574-236-700

2.25 Code Reading Contacts (continued)

Secondary Adjustments (continued)

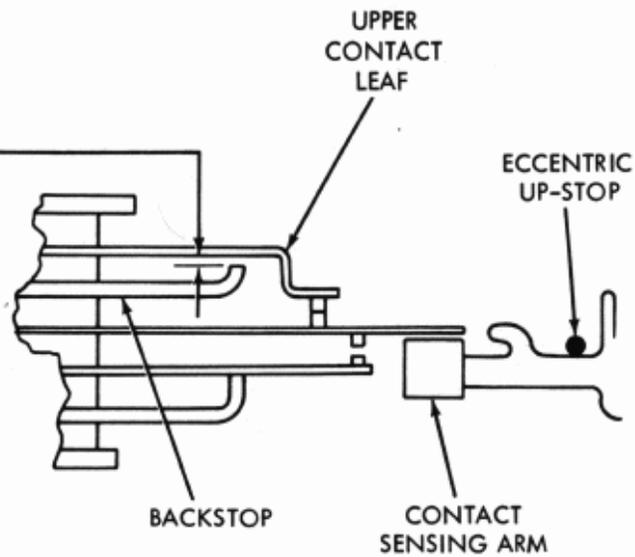
(A) ECCENTRIC UP-STOP REQUIREMENT

WITH LETTERS COMBINATION SELECTED, CLUTCH ENGAGED, AND MAIN SHAFT ROTATED UNTIL THE SENSING ARMS ARE IN THEIR UPPERMOST POSITION, THERE SHOULD BE

SOME --- TO --- 0.008 INCH CLEARANCE BETWEEN THE UPPER CONTACT LEAF AND ITS BACKSTOP.

TO ADJUST

LOOSEN THE NUT THAT SECURES THE ECCENTRIC UP-STOP TO THE FRONT PLATE AND TURN THE ECCENTRIC UNTIL THE REQUIREMENT IS SATISFIED. THE HIGH PART OF THE ECCENTRIC SHOULD BE TOWARD LEFT.



(B) SENSING ARM SPRING REQUIREMENT

WITH CLUTCH DISENGAGED

MIN 2-1/2 OZ

MAX 3-1/2 OZ

TO START SENSING ARM MOVING.

(C) SPLIT BAIL ECCENTRIC REQUIREMENT

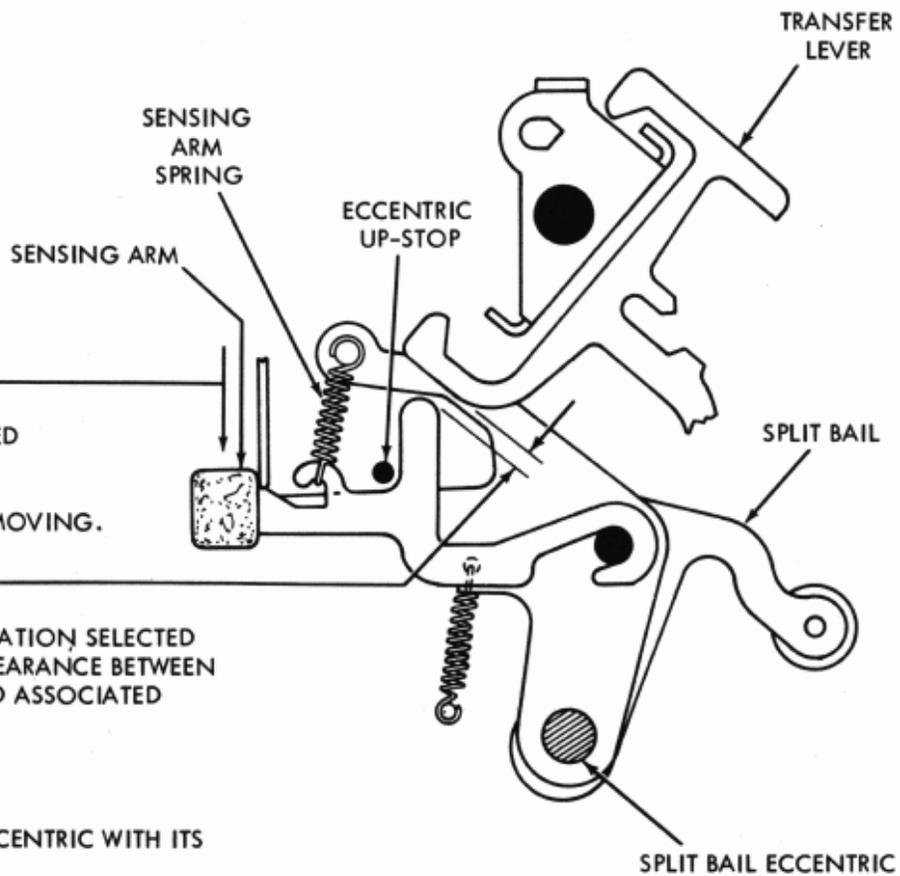
WITH THE BLANK COMBINATION SELECTED AND CLUTCH TRIPPED, CLEARANCE BETWEEN THE TRANSFER LEVERS AND ASSOCIATED SENSING ARMS.

MIN 0.020 INCH

MAX 0.030 INCH

TO ADJUST

ROTATE THE SPLIT BAIL ECCENTRIC WITH ITS LOCK NUT LOOSENED.



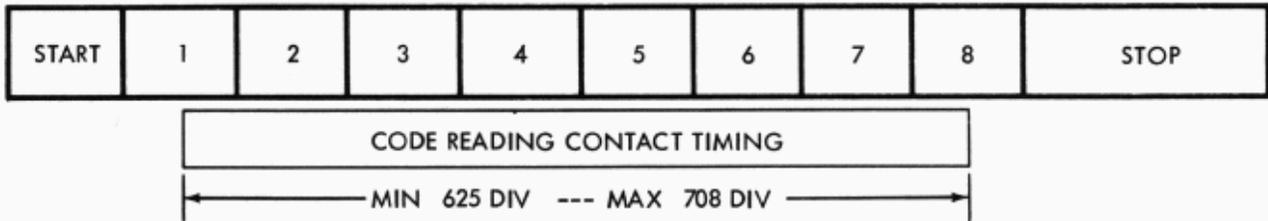
2.26 Code Reading Contacts (continued)

Final Adjustments (Strobing)

CONTACT BRACKET

NOTE

A DXD OPERATING AT 600 OPM WITH AN 11 UNIT CODE SCALE SHALL BE USED FOR STROBING.



REQUIREMENTS

- (1) MARKING PULSE (TRACE) LENGTH  
MIN 625 --- MAX 708 SCALE DIVISIONS
- (2) MARKING PULSE BREAKS TO BE CONFINED TO FIRST AND LAST 15 SCALE DIVISIONS OF TRACE.
- (3) SPACING PULSE (TRACE) LENGTH FULL SCALE TRACE WITHOUT BREAKS.

TO ADJUST

LOOSEN THE CONTACT BRACKET MOUNTING SCREWS AND POSITION BRACKET TO MEET REQUIREMENTS.

NOTE

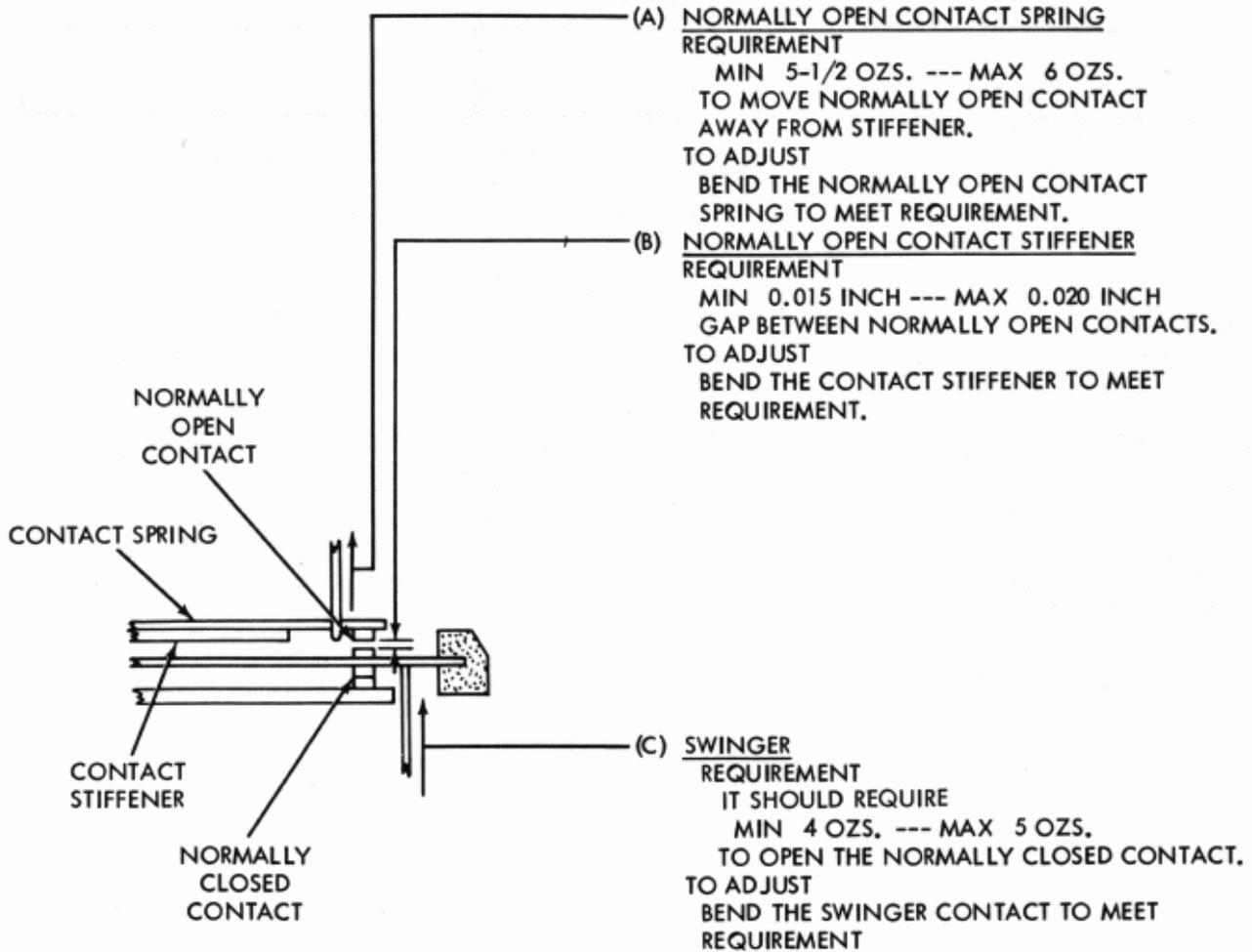
IF REQUIREMENTS CANNOT BE MET, RE-CHECK INITIAL AND SECONDARY ADJUSTMENTS AND REFINE IF NECESSARY.

2.27 Auxiliary No. 1 Contact Assembly

Initial Adjustments

NOTE

THE INITIAL ADJUSTMENTS SHOULD BE MADE WITH THE AUXILIARY CONTACTS REMOVED FROM THE TRANSMITTER UNIT.



## 2.28 Auxiliary No. 1 Contact Assembly (continued)

## Secondary Adjustments

## NOTE

THE SECONDARY ADJUSTMENTS SHOULD BE MADE WITH THE AUXILIARY CONTACTS INSTALLED.

## (A) CONTACT BRACKET

## REQUIREMENT

WITH CLUTCH DISENGAGED AND LATCHED,  
CLEARANCE BETWEEN THE INSULATOR ON  
THE SWINGER AND THE BAIL

MIN 0.025 INCH --- MAX 0.035 INCH

## TO ADJUST

POSITION THE CONTACT BRACKET WITH ITS  
MOUNTING SCREWS LOOSENED.

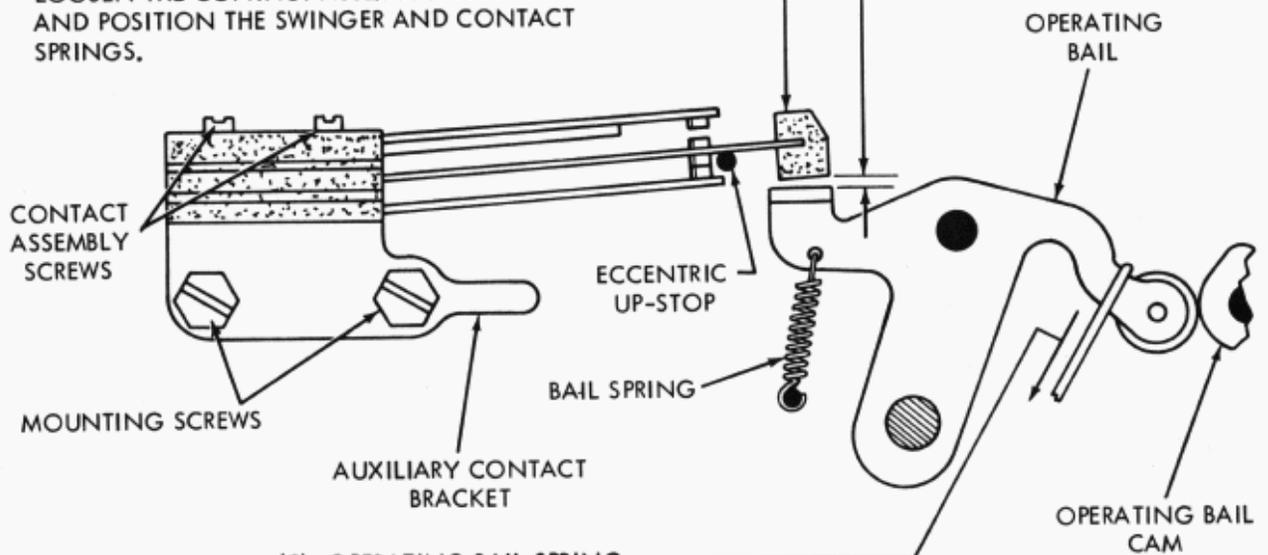
## (B) CONTACT ASSEMBLY

## REQUIREMENT

THE SWINGER INSULATOR SHOULD BE  
CENTRALLY LOCATED WITH RESPECT  
TO ITS OPERATING BAIL.

## TO ADJUST

LOOSEN THE CONTACT ASSEMBLY SCREWS  
AND POSITION THE SWINGER AND CONTACT  
SPRINGS.



## (C) OPERATING BAIL SPRING

## REQUIREMENT

CLUTCH DISENGAGED

MIN 5 OZ

MAX 7 OZ

TO MOVE FOLLOWER ROLLER AWAY FROM  
LOW PART OF ITS CAM.

SECTION 574-236-700

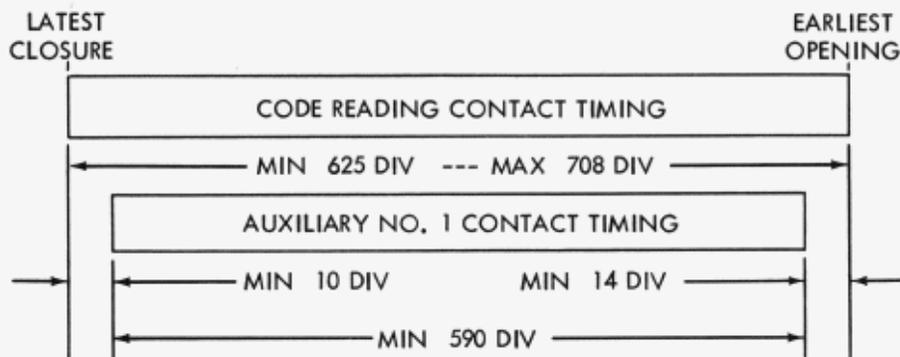
2.29 Auxiliary No. 1 Contact Assembly (continued)

Final Adjustment (Strobing)

CONTACT BRACKET

NOTE

A DXD OPERATING AT 600 OPM WITH AN 11 UNIT CODE SCALE SHALL BE USED FOR STROBING.



REQUIREMENT

- (1) AUXILIARY NO. 1 CONTACT TRACE SHALL BEGIN A MINIMUM OF 10 DIVISIONS AFTER LATEST CODE READING CONTACT HAS CLOSED, HAVE A MINIMUM PULSE LENGTH OF 590 DIVISIONS, AND END A MINIMUM OF 14 DIVISIONS BEFORE EARLIEST CODE READING CONTACT HAS OPENED.
- (2) TRACE MAY HAVE A MAXIMUM OF TWO 2-DIVISION BREAKS WITHIN 8 DIVISIONS OF THE START OR END OF TRACE.

TO ADJUST

LOOSEN THE CONTACT MOUNTING BRACKET SCREWS AND POSITION BRACKET TO MEET REQUIREMENTS.

NOTE

IF REQUIREMENTS CANNOT BE MET, RE-CHECK INITIAL AND SECONDARY ADJUSTMENTS.

### 3. VARIABLE FEATURES

#### 3.01 Auxiliary No. 2 Contact Assembly

##### Initial Adjustments

(A) BREAK-MAKE CONTACT SPRING

REQUIREMENT

MIN 4 OZ --- MAX 5 OZ  
TO OPEN NORMALLY CLOSED CONTACTS.  
TO ADJUST

BEND BREAK-MAKE CONTACT SPRING.

(B) MAKE CONTACT STIFFENER

REQUIREMENT

MIN 0.010 INCH --- MAX 0.020 INCH  
GAP BETWEEN NORMALLY OPEN CONTACTS.  
TO ADJUST

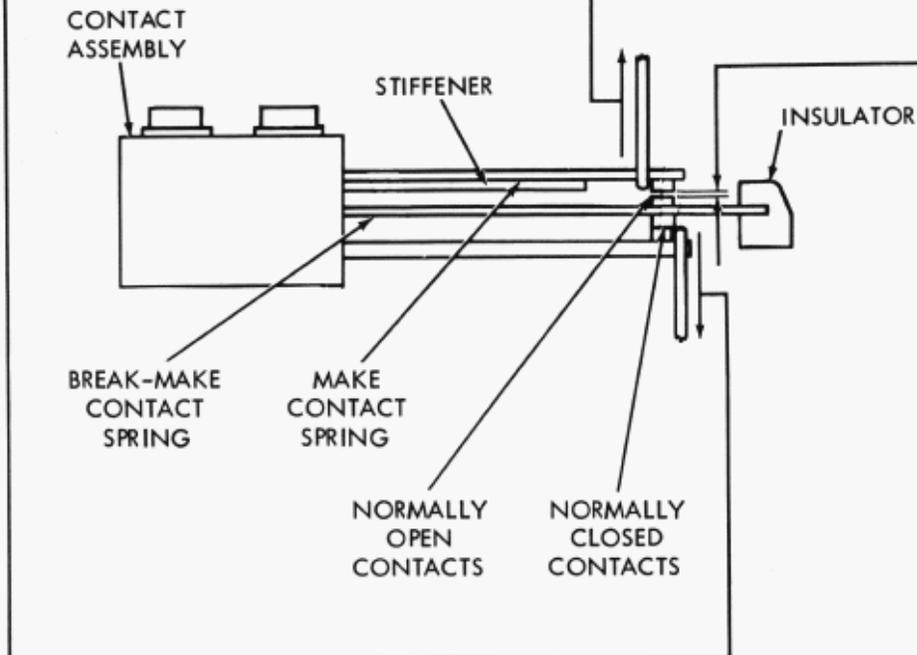
BEND STIFFENER.

(C) MAKE CONTACT SPRING

REQUIREMENT

MIN 5-1/2 OZ --- MAX. 6 OZ  
TO MOVE MAKE CONTACT SPRING AWAY FROM STIFFENER.  
TO ADJUST

BEND MAKE CONTACT SPRING.



SECTION 574-236-700

3.02 Auxiliary No. 2 Contact Assembly (continued)

Secondary Adjustments

(A) CONTACT BRACKET

TO CHECK

DISENGAGE AND LATCH CLUTCH.

REQUIREMENT

MIN 0.015 INCH --- MAX 0.020 INCH

CLEARANCE BETWEEN INSULATOR ON BREAK-MAKE CONTACT SPRING AND OPERATING SURFACE ON CAM FOLLOWER.

TO ADJUST

LOOSEN CONTACT MOUNTING BRACKET SCREWS AND POSITION CONTACT ASSEMBLY USING PRY POINT.

(B) CONTACT ASSEMBLY

TO CHECK

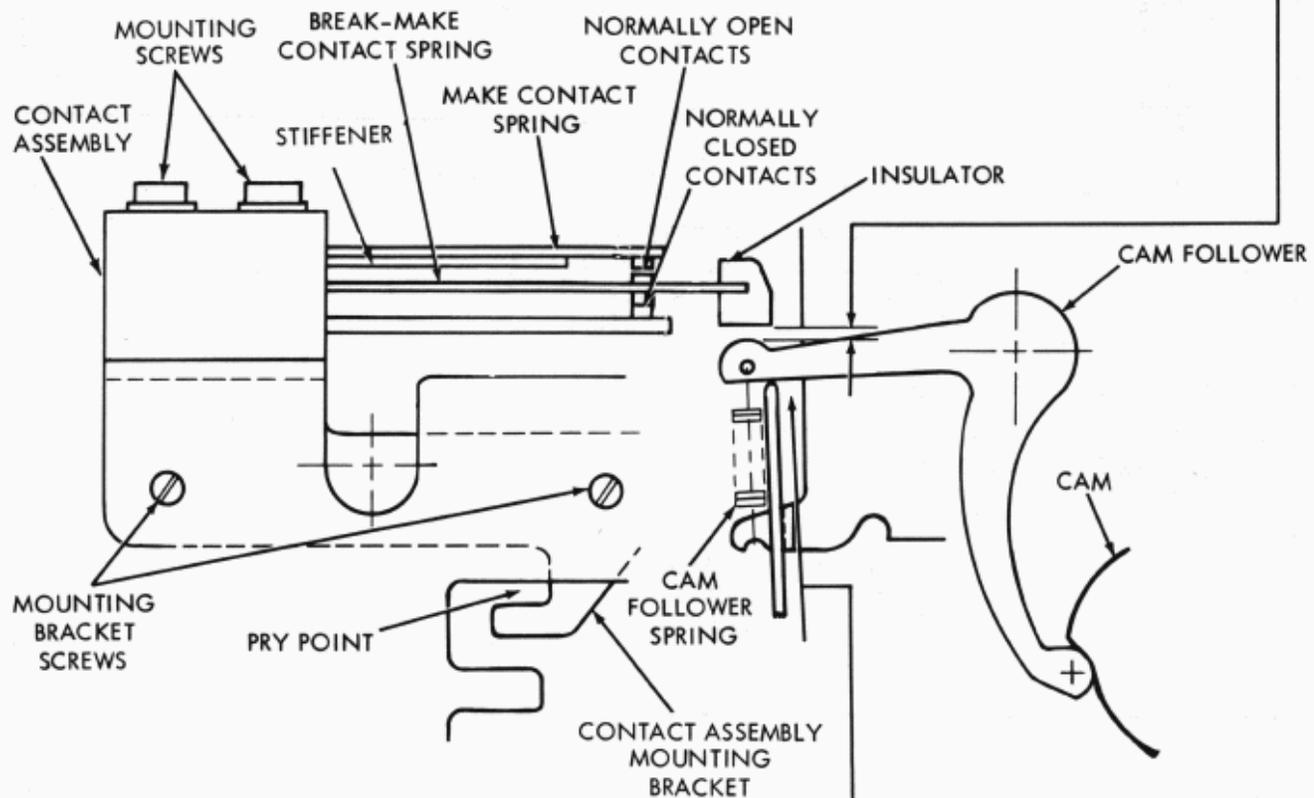
CLUTCH TRIPPED, ROTATE MAINSHAFT UNTIL INSULATOR ON BREAK-MAKE CONTACT SPRING IS IN CONTACT WITH CAM FOLLOWER.

REQUIREMENT

INSULATOR ON BREAK-MAKE CONTACT SPRING TO BE CENTRALLY LOCATED ON OPERATING FOLLOWER EXTENSION AND CONTACTS OF CONTACT SPRINGS TO BE ALIGNED.

TO ADJUST

LOOSEN CONTACT ASSEMBLY MOUNTING SCREWS AND POSITION CONTACT SPRINGS.



(C) CAM FOLLOWER SPRING

TO CHECK

DISENGAGE CLUTCH.

REQUIREMENT

MIN 2-1/2 OZ --- MAX 3-1/2 OZ

TO MOVE CAM FOLLOWER AWAY FROM CAM.

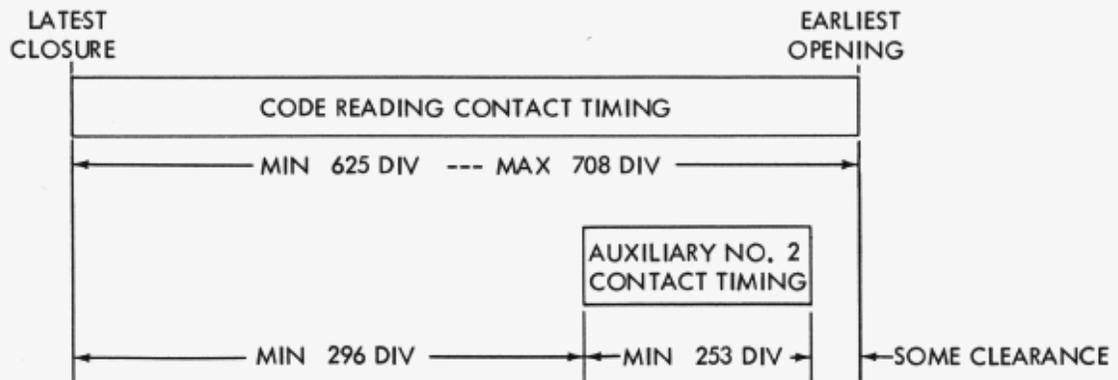
3.03 Auxiliary No. 2 Contact Assembly (continued)

Final Adjustments (Strobing)

CONTACT BRACKET

NOTE

A DXD OPERATING AT 600 OPM WITH AN 11 UNIT CODE SCALE SHALL BE USED FOR STROBING. DISCONNECT ONE END OF THE FILTER NETWORK BEFORE STROBING CONTACTS.



REQUIREMENT

- (1) AUXILIARY NO. 2 CONTACT TRACE SHALL BEGIN A MINIMUM OF 296 DIVISIONS AFTER LATEST CODE READING CONTACT HAS CLOSED, HAVE A MINIMUM PULSE LENGTH OF 253 DIVISIONS AND A MAXIMUM OF 275 DIVISIONS, AND END A MINIMUM OF 21 DIVISIONS BEFORE EARLIEST CODE READING CONTACTS HAVE OPENED.
- (2) TRACE MAY HAVE A 2-DIVISION BREAK WITHIN THE FIRST AND LAST 8 SCALE DIVISIONS OF THE TRACE.

TO ADJUST

LOOSEN THE CONTACT MOUNTING BRACKET SCREWS AND POSITION BRACKET TO MEET REQUIREMENTS.

NOTE

IF THE REQUIREMENT CANNOT BE MET, RE-CHECK INITIAL AND SECONDARY ADJUSTMENTS.